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FIG. 1

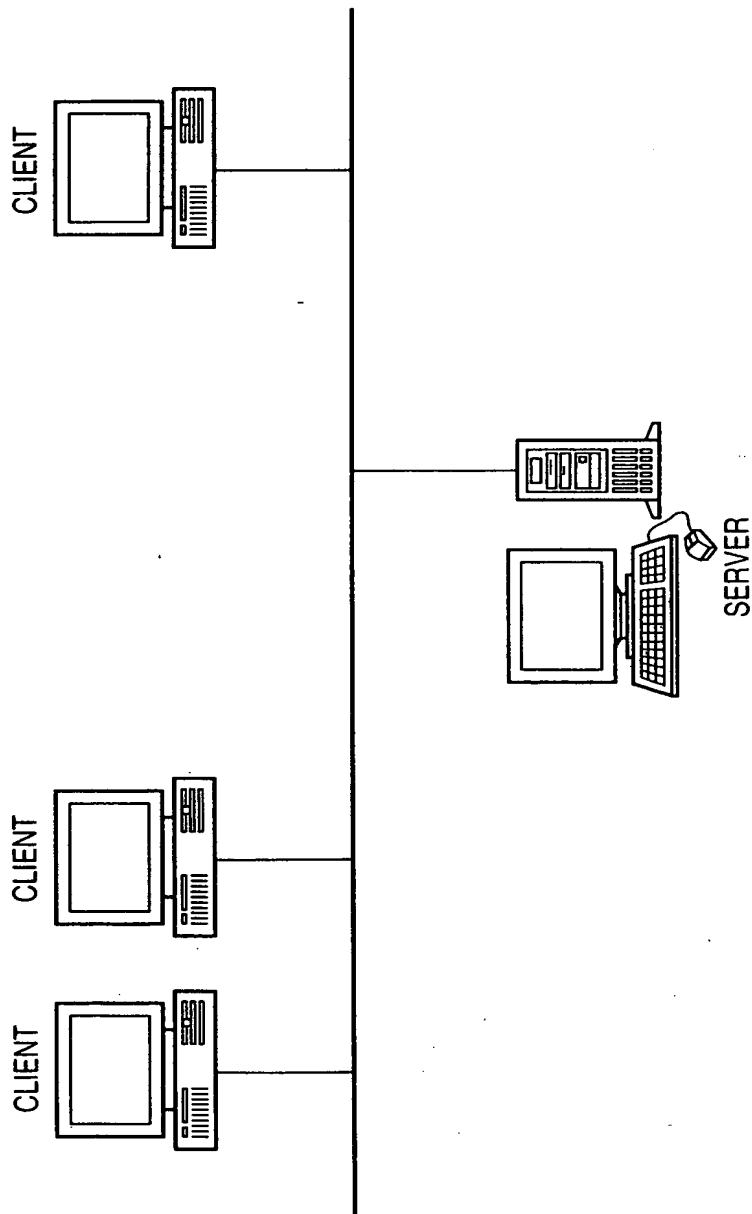


FIG. 2

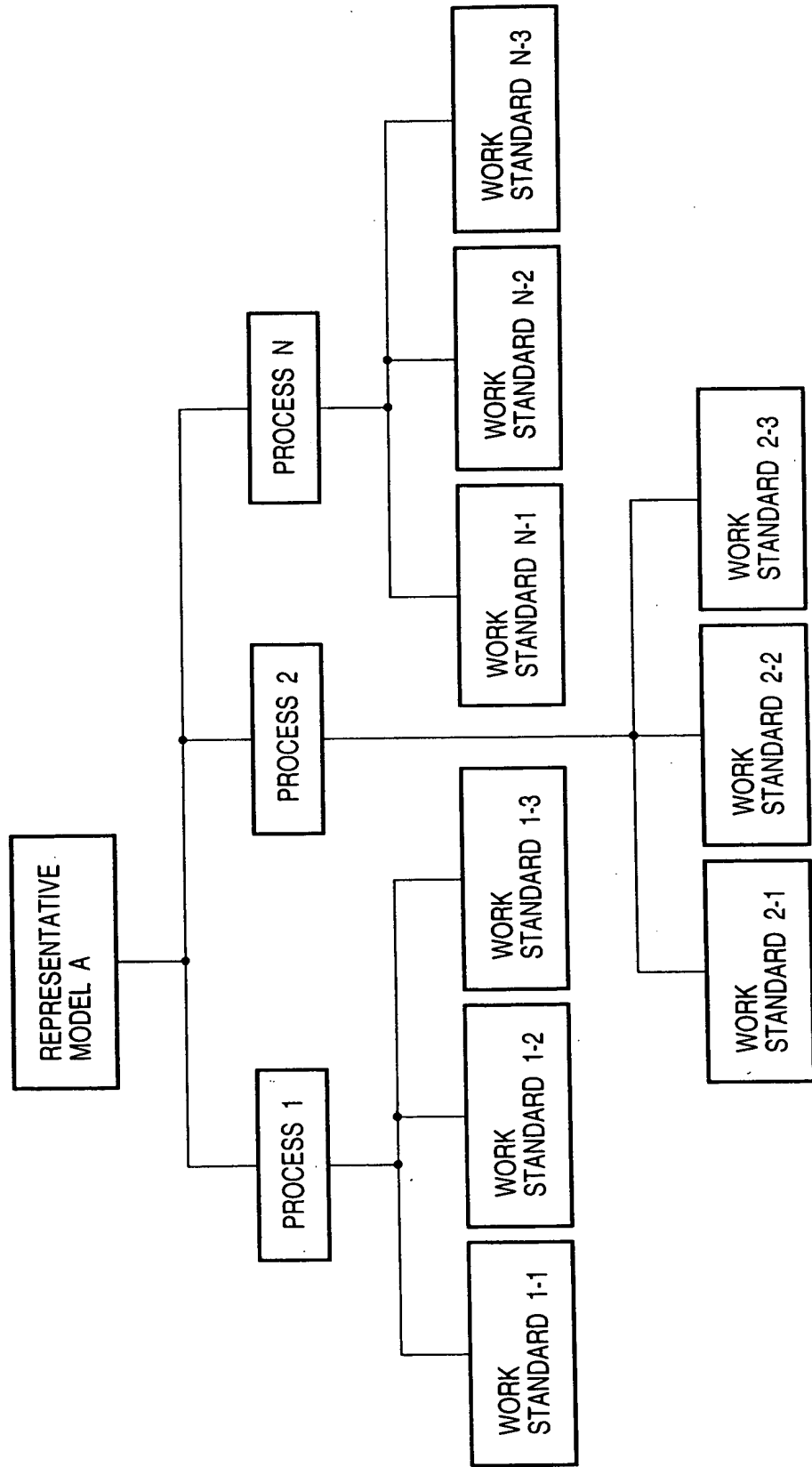


FIG. 3

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WORK STANDARD 01 CREATION

APPLIED

PART NUMBER	PART NAME	QUANTITY	PART NUMBER	PART NAME	QUANTITY
303	304	305			

TOOL / TREATMENT DEVICE / AUXILIARY MATERIAL

QUANTITY	CHECK ETC.
306	307
	308

No. WORK PROCEDURE No. NOTE / STANDARD ETC.

310

REVISION NUMBER	CONTENTS OF REVISION	DATE	PERSON IN CHARGE	APPROVE
01	CREATED	1997/09/25		

WORK NAME

MANAGEMENT NO.

FIG. 4

STRUCTURE OF MASTER FILE

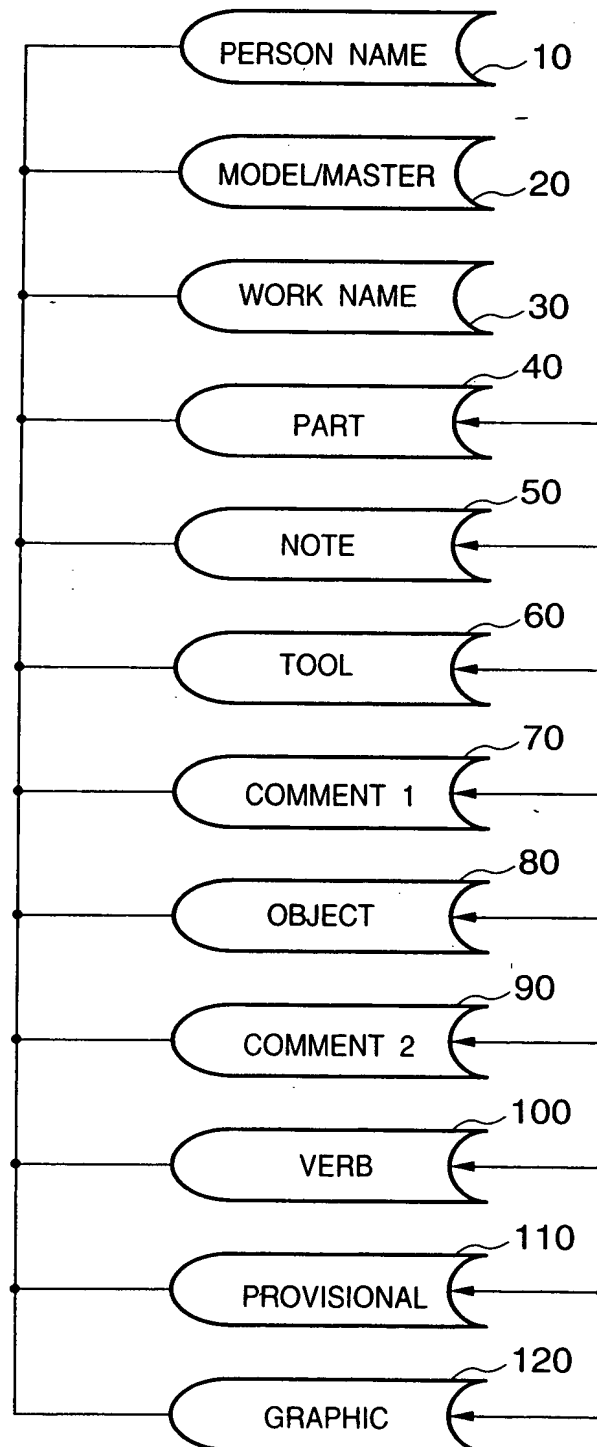


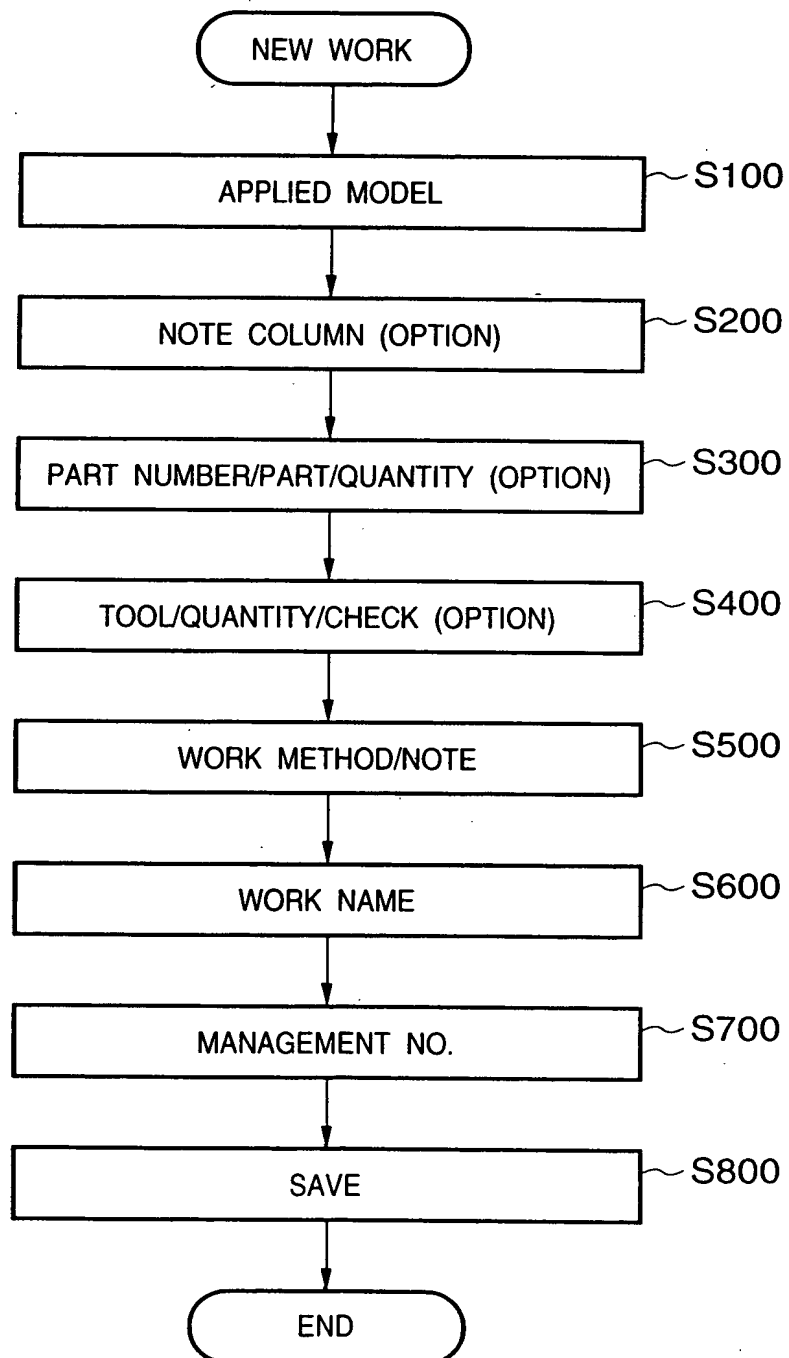
FIG. 5

FIG. 6

SELECTION OF APPLIED MODEL
LIST OF APPLIED MODELS
BJC-4200 SYSTEM
BJC-420J
BJC-420J (BLACK)
BJC-4300
BJC-430J
BJC-4200LX
A250 II Q
BJC-4200
OK
CANCEL

FIG. 7

WORK STANDARD 01 CREATION					<input type="button" value="-"/> <input type="button" value="□"/> <input type="button" value="X"/>		
APPLIED		BJC-420J BJC-420J(BLACK) BJC-430J					
PART NUMBER		PART NAME		PART NUMBER		QUANTITY	
						▲	

302

FIG. 8

PART NUMBER	PART NAME	QUANTITY	PART NUMBER
PART			
000 - 0000 - 001	PART 001	▲	
000 - 0000 - 002	PART 002		
000 - 0000 - 003	PART 003		
001 - 0000 - 001	PART 101	▼	
001 - 0000 - 002	PART 102		
111 - 1111 - 001	PART 001		
A01 - 1234 - 001	TEST PART 0001		

FIG. 9

• WORK NAME

• CANDIDATES

- (SET ORIGINAL GLASS PROTECTIVE SHEET)
- (HOOK DEVELOPING RAIL RETURN SPRING)
- (HOOK DEVELOPING RAIL RETURN SPRING(AFTER))
- (SET ORIGINAL GLASS TABLE)
- (SET ORIGINAL TABLE PROTECTIVE SHEET)
- (CHECK NO TONER IN DEVELOPER)
- (CHECK ERROR IN DEVELOPER)
- (LOCK DEVELOPER)

A curved arrow originates from the right side of the 'WORK NAME' input field and points towards the top right corner of the task list box.

FIG. 10

• WORK NAME

• CANDIDATES

(HOOK DEVELOPING RAIL RETURN SPRING)

(HOOK DEVELOPING RAIL RETURN SPRING(AFTER))

(CHECK NO TONER IN DEVELOPER)

(CHECK ERROR IN DEVELOPER)

(LOCK DEVELOPER)

FIG. 11

1100

WORK STANDARD SYSTEM

WORK NAME :

WORK METHOD :

1101 (COMMENT 1)

1102 (OBJECT)

1103 (COMMENT 2)

1104 (VERB)

1105a

1105b

1105

00 *

01

NOTE, STANDARD / REQUIRED QUALITY :

1106

1107

OK CANCEL

1108

11/97

12/97

FIG. 12

WORK STANDARD SYSTEM

WORK NAME :

WORK METHOD :

1201

1202

1105b

00 ※

01

The diagram shows a form with a header 'WORK STANDARD SYSTEM'. Below it are two labels: 'WORK NAME :' and 'WORK METHOD :'. There are three input fields: a single-line field labeled 1201, a multi-line field labeled 1202, and a single-line field labeled 1105b. The 1105b field contains the text '00 ※'. Below this field is another field containing '01'. The entire form is enclosed in a rectangular border with a wavy line at the bottom left corner.

FIG. 13

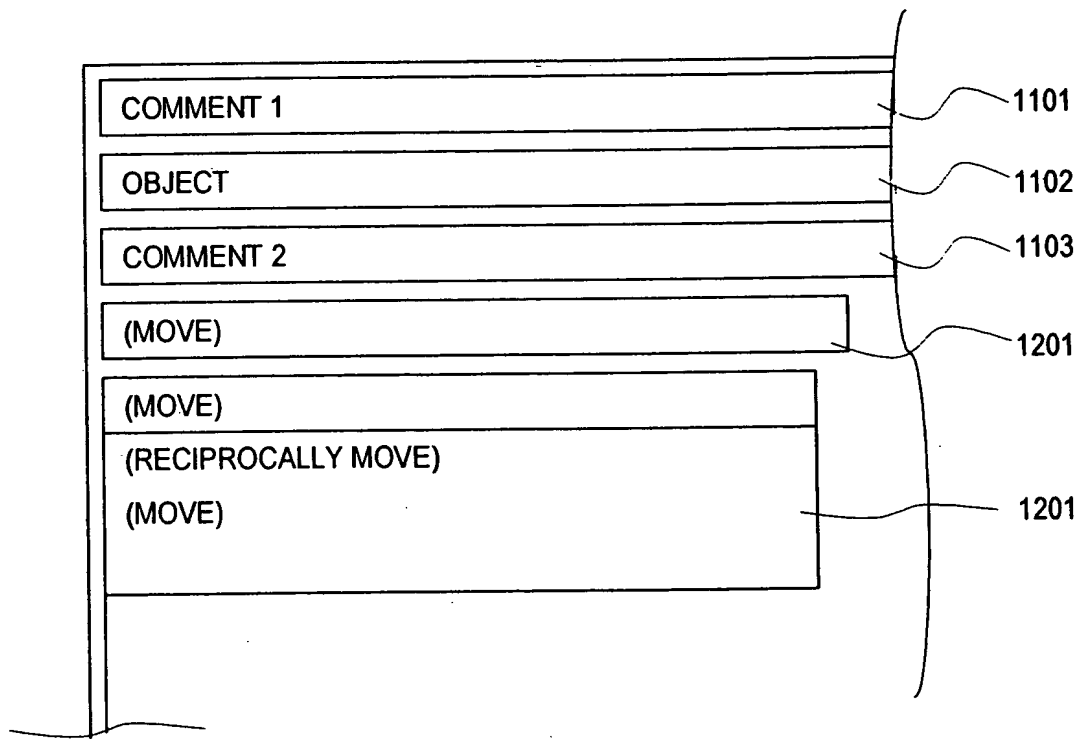


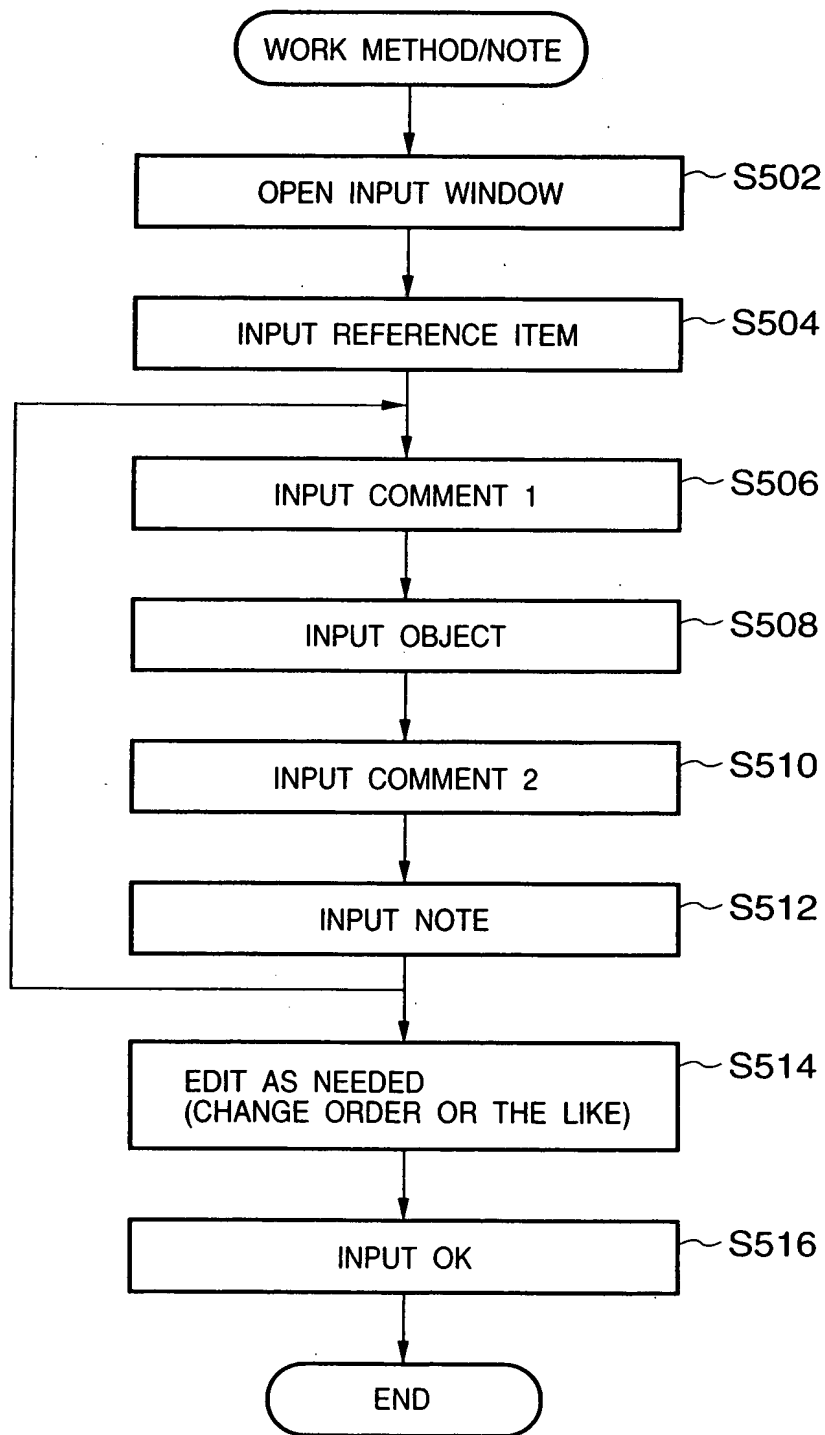
FIG. 14

FIG. 15

00	※	
01	DO zzzz SUCH THAT xxxx AT wwww POSITION BECOMES yyyy	
02	WIND AV CORD	
03	CONFIRM 100V SYSTEM	
04	SET CRG HOLDER	

FIG. 16

NOTE, STANDARD / REQUIRED QUALITY	1601
NOTE	
SEPARATION GRIPPER MOVES SLOWLY WITHOUT GRIPPER SPRING OF ASFu DON'T PULL TAPE TOO STRONG TO MAKE SIDE GUIDE LOOSE DON'T HOOK PAPER GUIDE u ON SHEET HOLDER BEWARE OF IMITATIONS BEWARE OF IMITATIONS(Color Style Write	1602

FIG. 17

NOTE, STANDARD / REQUIRED QUALITY	
1	NOTE

1107

FIG. 18

CONFIRM	
00 ※	
01 CONFIRM 100V SYSTEM	
02 WIND AV CORD	CUT(I)
03 SET CRG HOLDER	COPY(C)
04	PASTE(P)
	ADD(A)
	DELETE(D)
	UNDO
	REVISE(CHANGE)
	REVISE(DELETE)
NOTE, STANDARD / REQUIRED QUALITY	

1802

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FIG. 19

CONFIRM
00 ※
01 WIND AV CORD
02 CONFIRM 100V SYSTEM
03 SET CRG HOLDER
04

NOTE, STANDARD / REQUIRED QUALITY

FIG. 20

CONFIRM

00 ※

01 WIND AV CORD

02 SET CRG HOLDER

03

CUT(I)

COPY(C)

PASTE(P)

ADD(A)

DELETE(D)

UNDO

REVISE(CHANGE)

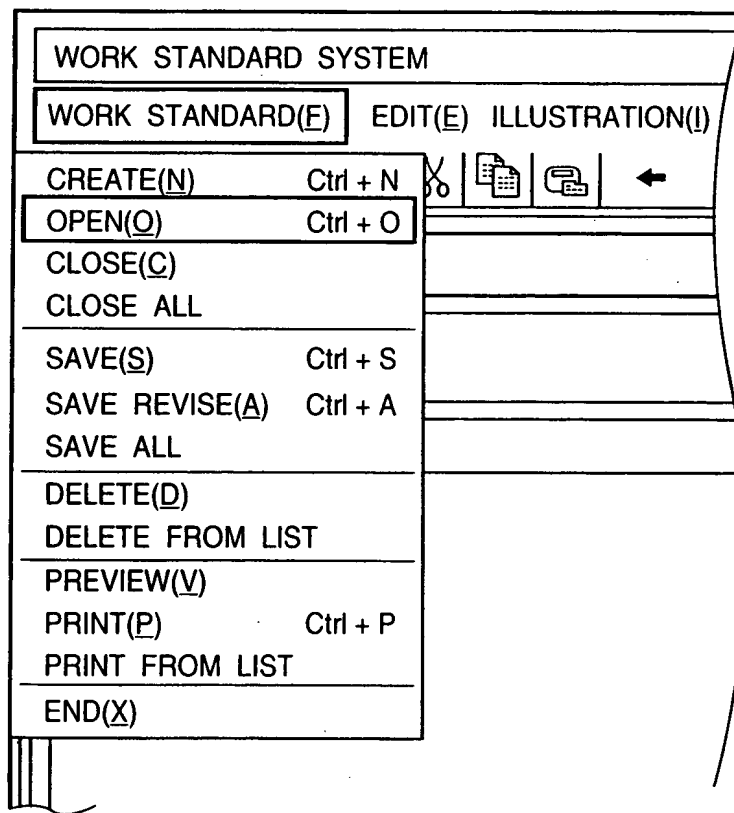
REVISE(DELETE)

NOTE, STANDARD / REQUIRED QUALITY

1802

FIG. 21

WORK STANDARD SYSTEM	
WORK STANDARD(E)	EDIT(E) ILLUSTRATION(I) SHIPMENT DESTINATION
CREATE(N) Ctrl + N	✂ 📄 📄 ←
OPEN(O) Ctrl + O	
CLOSE(C)	
CLOSE ALL	
SAVE(S) Ctrl + S	
SAVE REVISE(A) Ctrl + A	
SAVE ALL	PART
DELETE(D)	
DELETE FROM LIST	
PREVIEW(V)	
PRINT(P) Ctrl + P	
PRINT FROM LIST	
END(X)	

FIG. 22

23/97

2301

FIG. 24





SYSTEM			
EDIT(E)		ILLUSTRATION(I)	SHIPMENT DESTINATION(S)
		VIEW(V)	 
		EDIT(E)	
01 CREATE		PowerPoint	
		✓ Canvas	

FIG. 25

2500

302

WORK STANDARD 01 CREATION

APPLIED

PART NUMBER PART NAME

303

TOOL / TREATMENT DEVICE

WORK PROCEDURE

No.

FILE NAME :

2501 2502 2503 2504

CLOSE CLEAR UPDATE

REVISION NUMBER CONTENTS OF REVISION DATE PERSON IN CHARGE APPROVE

01 CREATED 1997/09/25

WORK NAME

MANAGEMENT NO.

FIG. 26

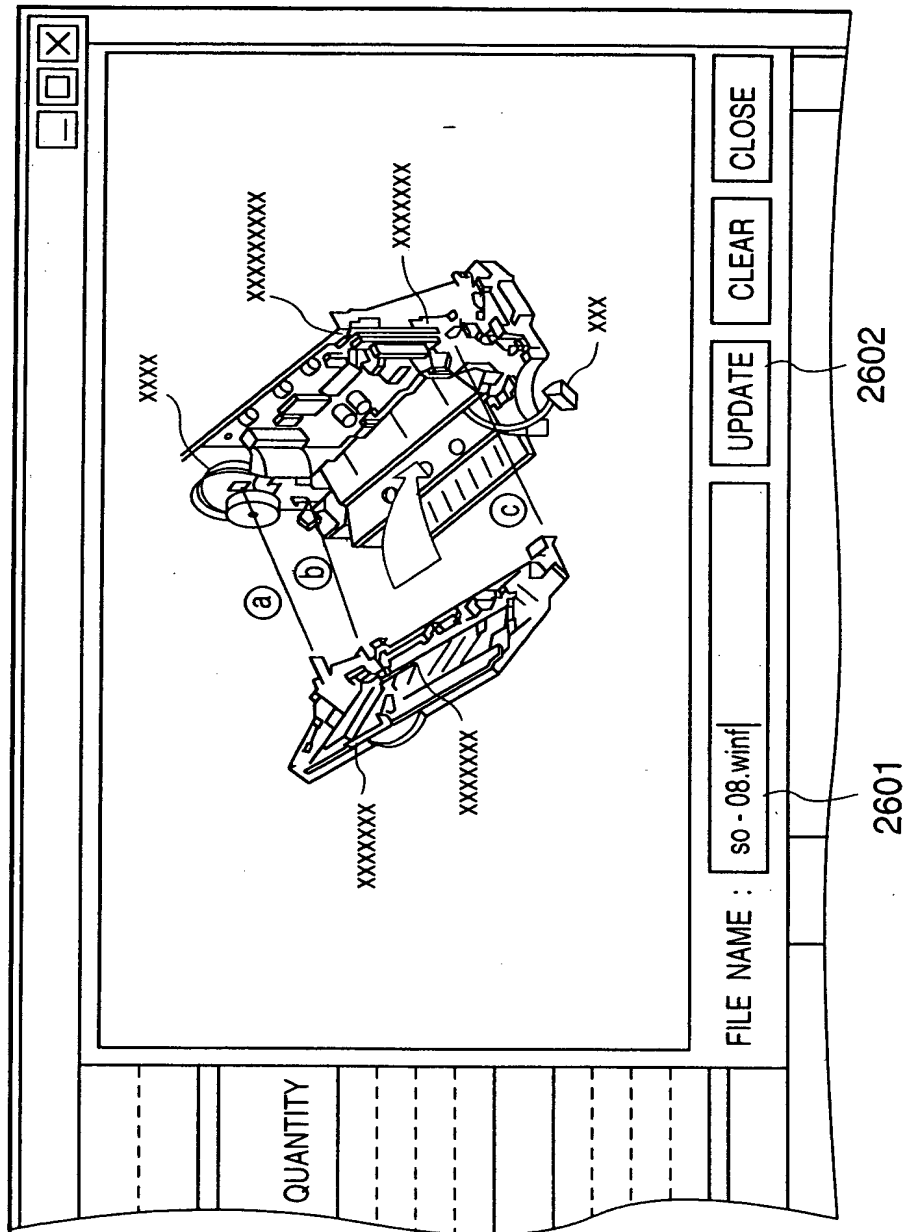


FIG. 27

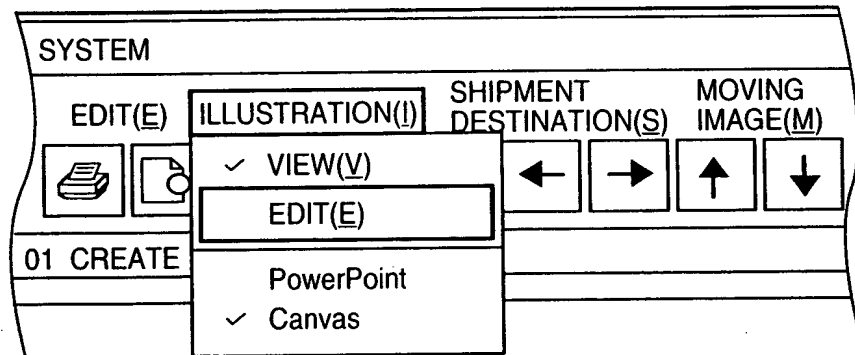
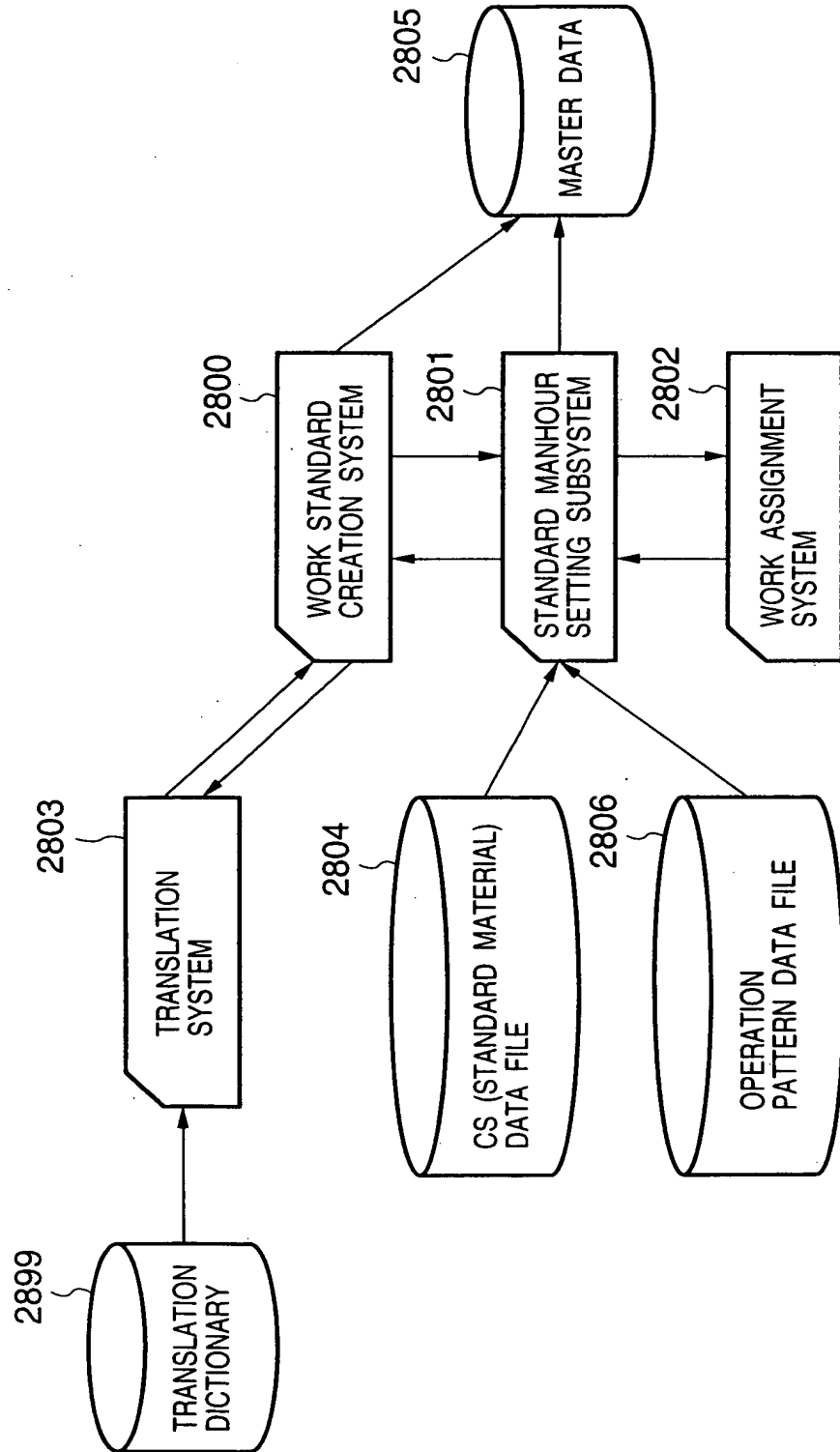


FIG. 28



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FIG. 29

WORK STANDARD : TRANSLATION SYSTEM (PROTOTYPE) [X]

☒ WORK STANDARD DATA
☐ MASTER DATA

UPLOAD WORK STANDARD

DOWNLOAD WORK STANDARD

TRANSLATE WORK STANDARD

END

FIG. 30

3001 3002 3003 3004

TRANSLATION OF WORK STANDARD

REPRESENTATIVE MODEL NAME : A252

PREPUCES NAME : PLATEN UNIT

☐ TOTAL
☒ ASSEMBLY

☒ UNIT
☐ ASSEMBLY

DISPLAY DATA

☒ ALL
☐ UNTRANSLATED
☐ UNCHECKED

DISPLAY LANGUAGE

☐ JAPANESE
☒ ENGLISH

3000

MANAGEMENT NO.	REVISION NUMBER	WORK NAME	AUTOMATIC TRANSLATION	CHECK
PT - 010 - 010	01	SET CLEANER UP	X	X
PT - 010 - 020	01	SET CLEANER UP	X	X
PT - 010 - 030	01	SET CLEANER UP	X	X
PT - 070 - 030	01	ASSEMBLE CHANGEOVER ARM	X	X
PT - 080 - 010	01	SET TRANSMISSION ROLLER	X	X
PT - 090 - 010	01	SET TRANSMISSION ROLLER	X	X
PT - 100 - 010	01	SET SHEET HOLDER	X	X

3006

3007 3008 3005

3101

FIG. 32

3200

WORK PROCEDURE ✕	
VOICE(W)	
JAPANESE	
WORK PROCEDURE	
ブレードレバ-ハネをブレードレバ-の ① 部に引っ掛ける	<div style="border: 1px solid black; padding: 5px;"> <p>01 ブレードレバ-ハネをブレードレバ-の ① 部に引っ掛ける</p> <p>02 ブレードレバ-を矢印 ② 方向にスライドさせ引っ掛かり無くハネ力で戻ることを確認する</p> <p>03 ブレードレバ-軸先端がブレードホルダ-先端まで圧入されていることを確認する</p> </div>
ENGLISH	
Procedure	
The blade lever spring hooks to ① of the blade lever.	<div style="border: 1px solid black; padding: 5px;"> <p>01 The blade lever spring hooks to ① of the blade lever.</p> <p>02 Side the blade lever in the direction of arrow ② and there is no catch and n....</p> <p>03 Check press-fitting the blade lever shaft leading edge to the braid folder leading ed....</p> </div>
<div style="display: flex; justify-content: space-between; align-items: center;"> ◀ ▶ </div>	
<div style="display: flex; justify-content: flex-end; gap: 10px;"> <div style="border: 1px solid black; padding: 2px 10px;">TRANSLATE</div> <div style="border: 1px solid black; padding: 2px 10px;">OK</div> <div style="border: 1px solid black; padding: 2px 10px;">CANCEL</div> </div>	

3201

3202

3203

3204

FIG. 33

TRANSLATION OF WORK STANDARD (PROTOTYPE)		<div> <div></div> <div></div> <div></div> </div>	
WORK STANDARD(E) ILLUSTRATION(I)		VOICE(S)	HOW(W)
WORK STANDARD PN-030-020 01 Net		PLAY(P)	PLAYX2056) A252 PLATEN UNIT
		NEW(N)	
Model QG5-1317		DRIVE(D)	

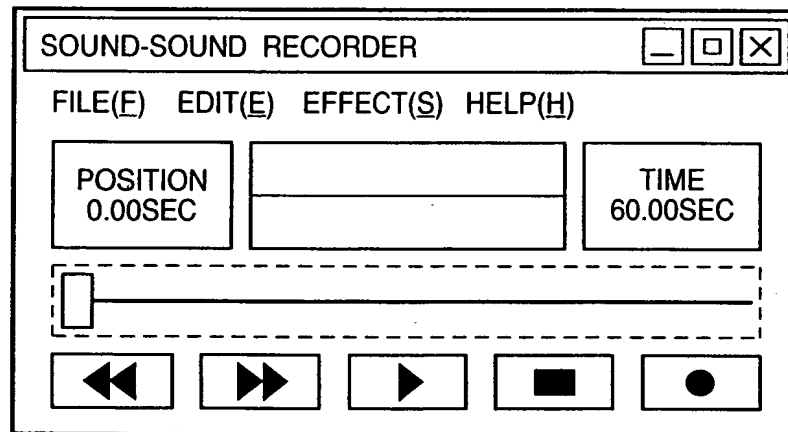
FIG. 34

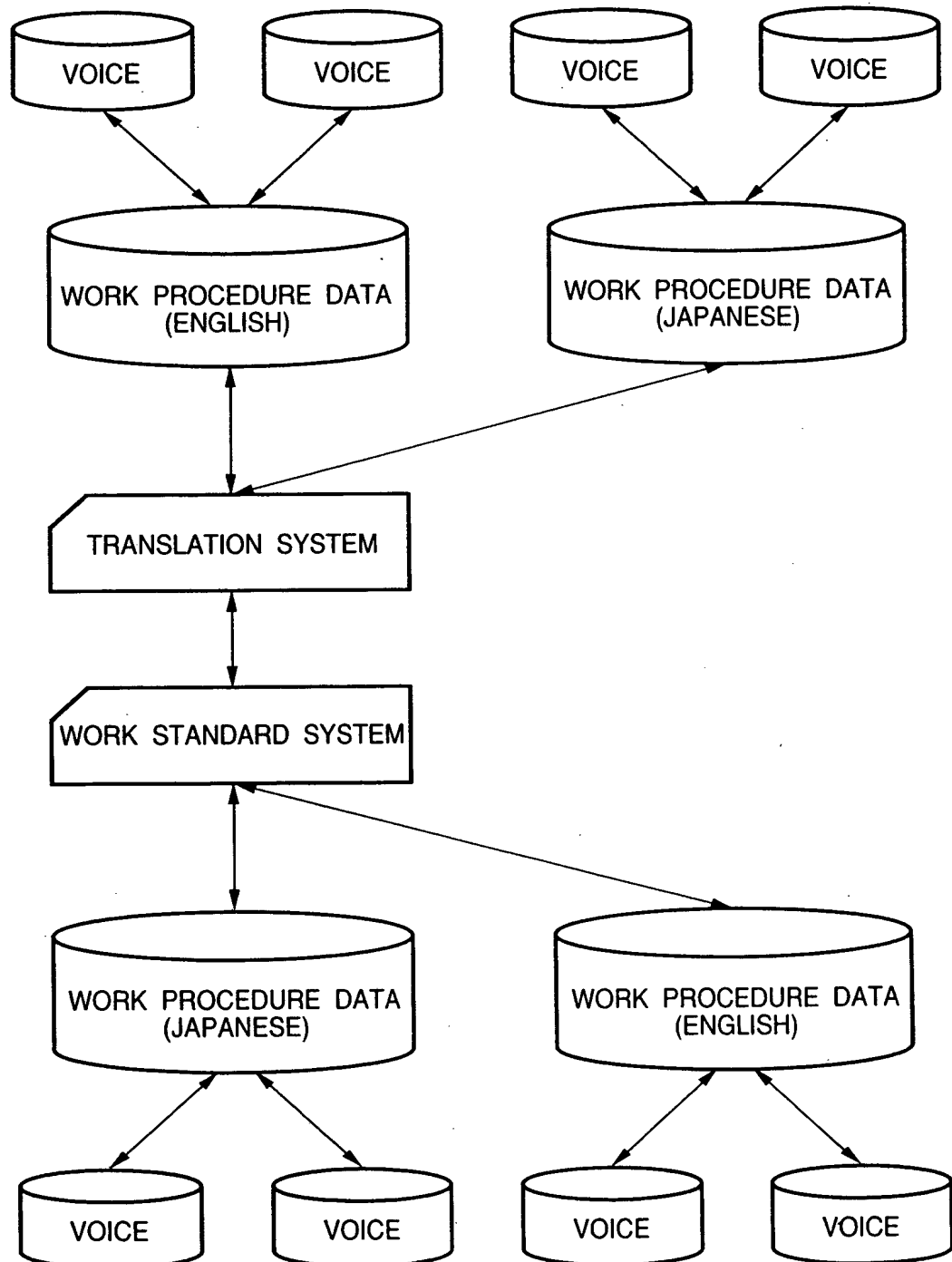
FIG. 35

FIG. 36

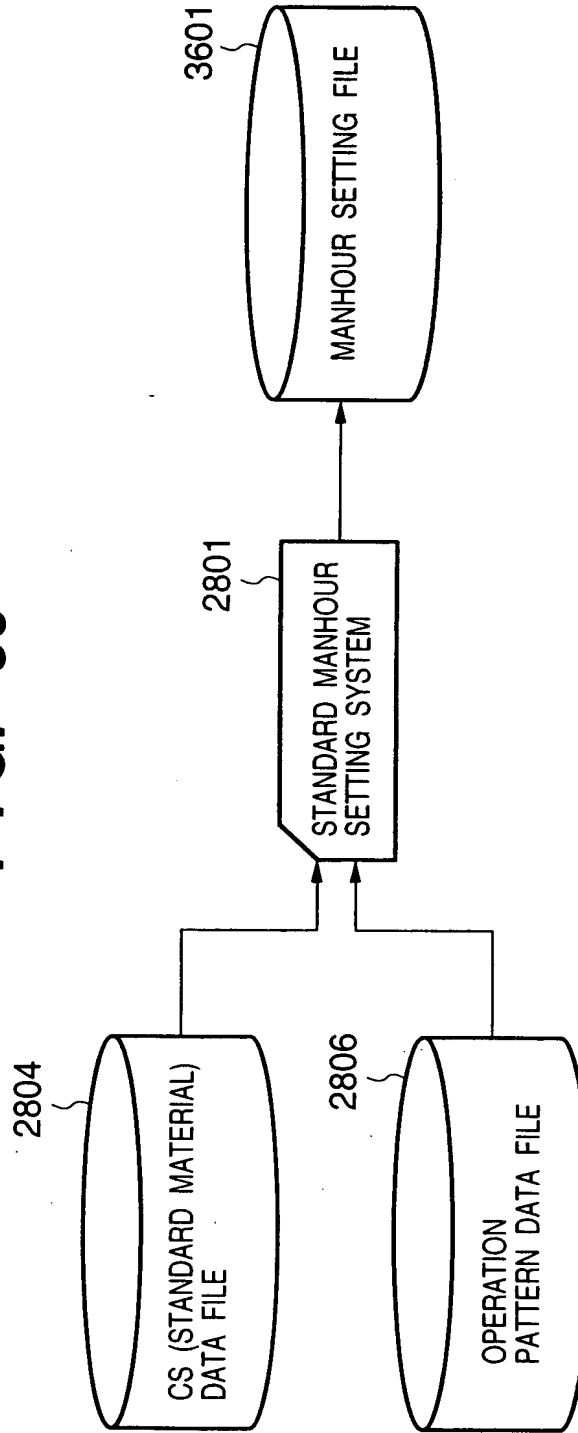


FIG. 37

No.	ELEMENT WORK NAME	FREQUENCY		MANHOUR	CS	SET CONDITION

FIG. 38

STANDARD MATERIAL DATA

COMMENT 1	OBJECT	COMMENT 2	VERB	SET CONDITION DATA

FIG. 39

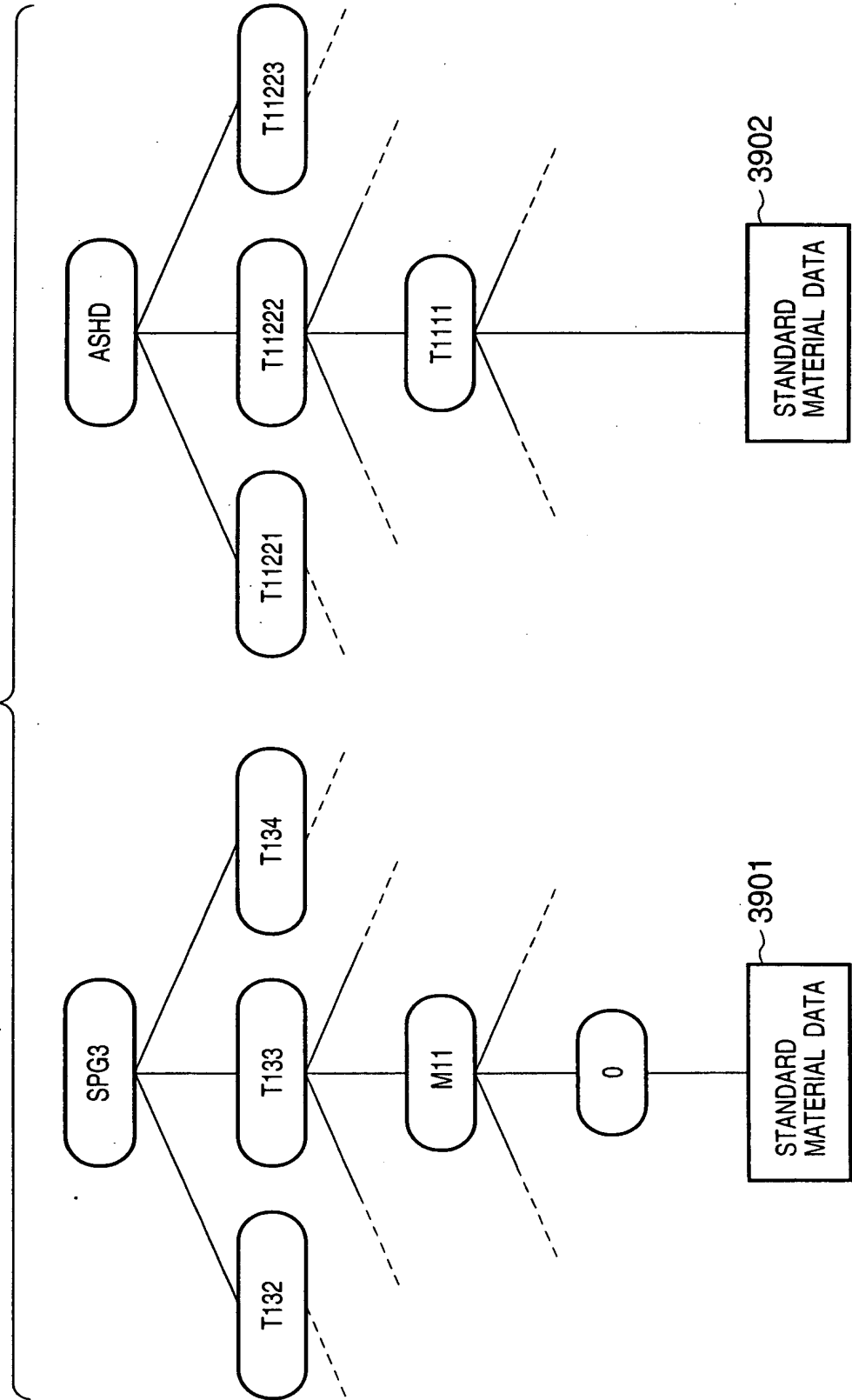


FIG. 40

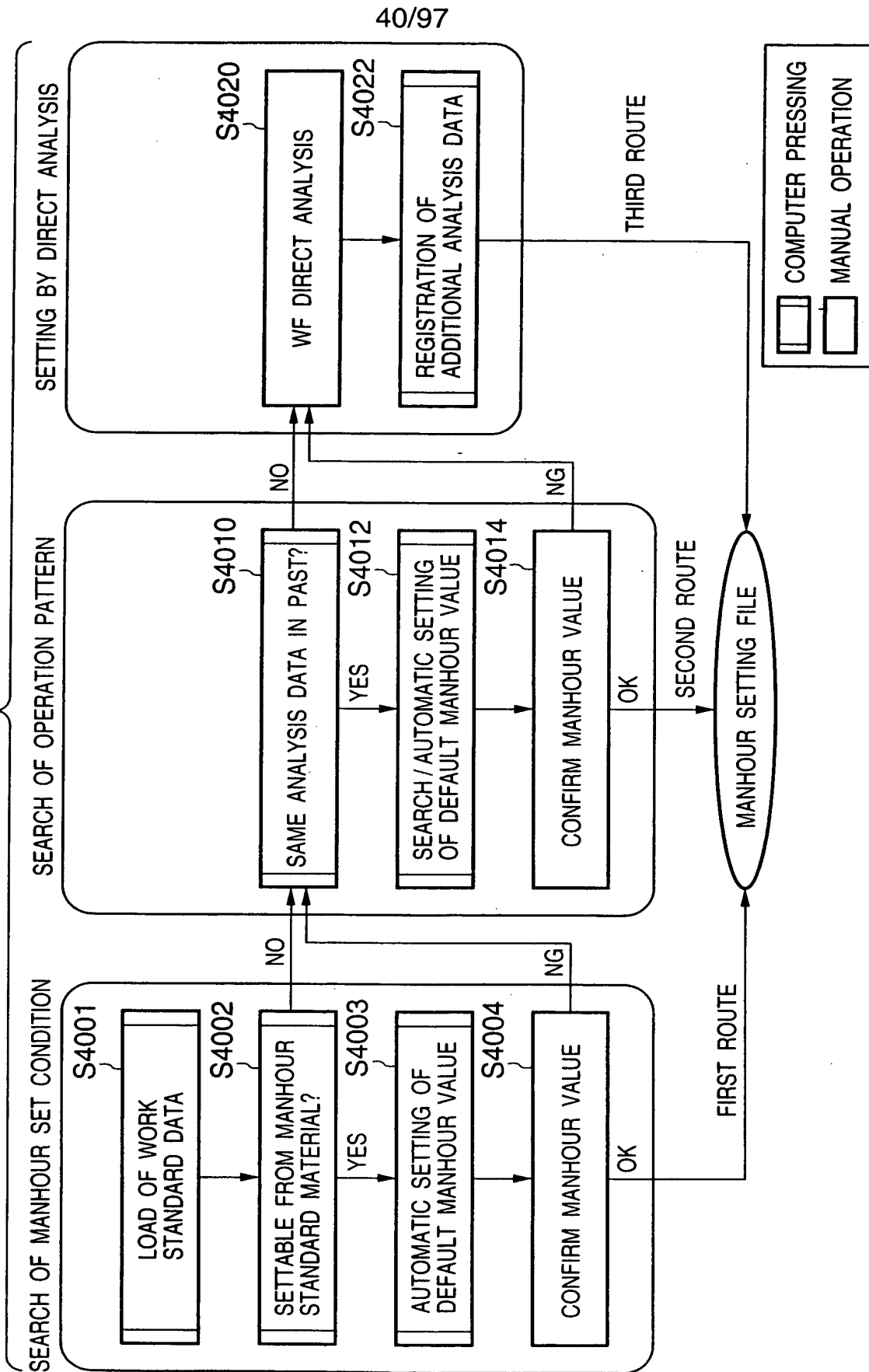


FIG. 42

3601

EDITING OF ELEMENT WORK							
FILE(F) EDIT(E) VIEW(V) ANALYZE(A) ANALYSIS MATERIAL(B) CS(S) END(X)							
UNIT WORK NAME : SEPARATION ROLLER ATTACHMENT							
No.	ELEMENT WORK NAME	FREQUENCY		MANHOUR	CS	SET CONDITION	
1	(SET LOAD SPRING IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1	41	SPG3	T133 / M11 / O	
2	(TURN ON SW OF TREATMENT DEVICE)	1	1	8			
3	(SET SEPARATION ROLLER SHAFT IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1	37	ASHD	T11222 / T1111	
4	(TURN OFF SW OF TREATMENT DEVICE)	1	1	8			
5	(DETACH SEPARATION ROLLER SHAFT FROM TREATMENT DEVICE)	1	1	16	PUMB	T2111 / T111111	

MATCH

SEARCH KEYWORD (KW)

No.	COMMENT 1	OBJECT	COMMENT 2	VERB	MANHOUR STANDARD MATERIAL	TIME VALUE
1	*	SPRING	TO *	SET	SPG3 T133/M11/O	41RU
2	*	*	TO *	SET	ASHED T11222/T1111	37RU
3	*	*	FROM *	DETACH	PUMQ T2111/T111111	16RU
4	*	E-RING	*	SET	RIN2 T11211/SO	76RU
5	*	CONNECTOR	*	INSERT	CONN T11211/SO	41RU
6	*	*	*	SCREW TIGHTLY	SCR6 M211/I	23RU

2804

FIG. 44

[illegible]

FIG. 45

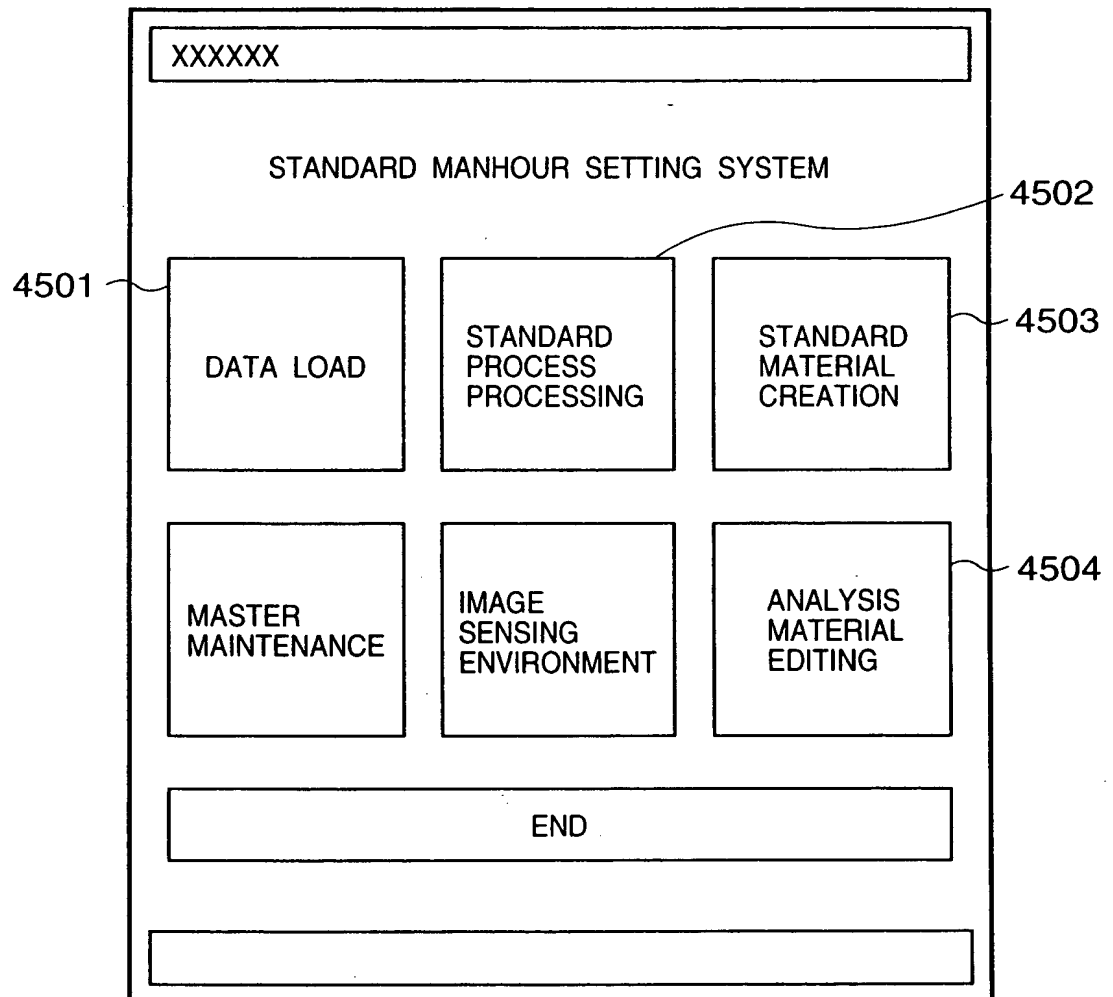


FIG. 46

4609 4610 4612

XXXXXXX

☒ ALL ☐ DESIGNATE :

PRODUCT NUMBER: NAME:

PRODUCT NUMBER	WORK STANDARD	PRODUCT SYMBOL	NAME	PREVIOUS LOAD DATE
0 - CLOCK	XXXX	XX	XXXX	XXX
XXXXXX		BL - OLD	SET IN 1996	
xyz - test				
test - 01				
tesr - AMI				

4601 4602 4603 4604 4605

FIG. 47

[illegible]

FIG. 48

4805 4804

LOAD OF DATA

4800

COMPONENT DESIGNATION

4801

☐ ALL

☒ DESIGNATE COMPONENT

4802

CH

AUTOMATIC MANHOUR SETTING

☒ STANDARD MATERIAL(CS)

☒ ANALYSIS MATERIAL

4803

EXECUTE

CANCEL

4806

FIG. 49

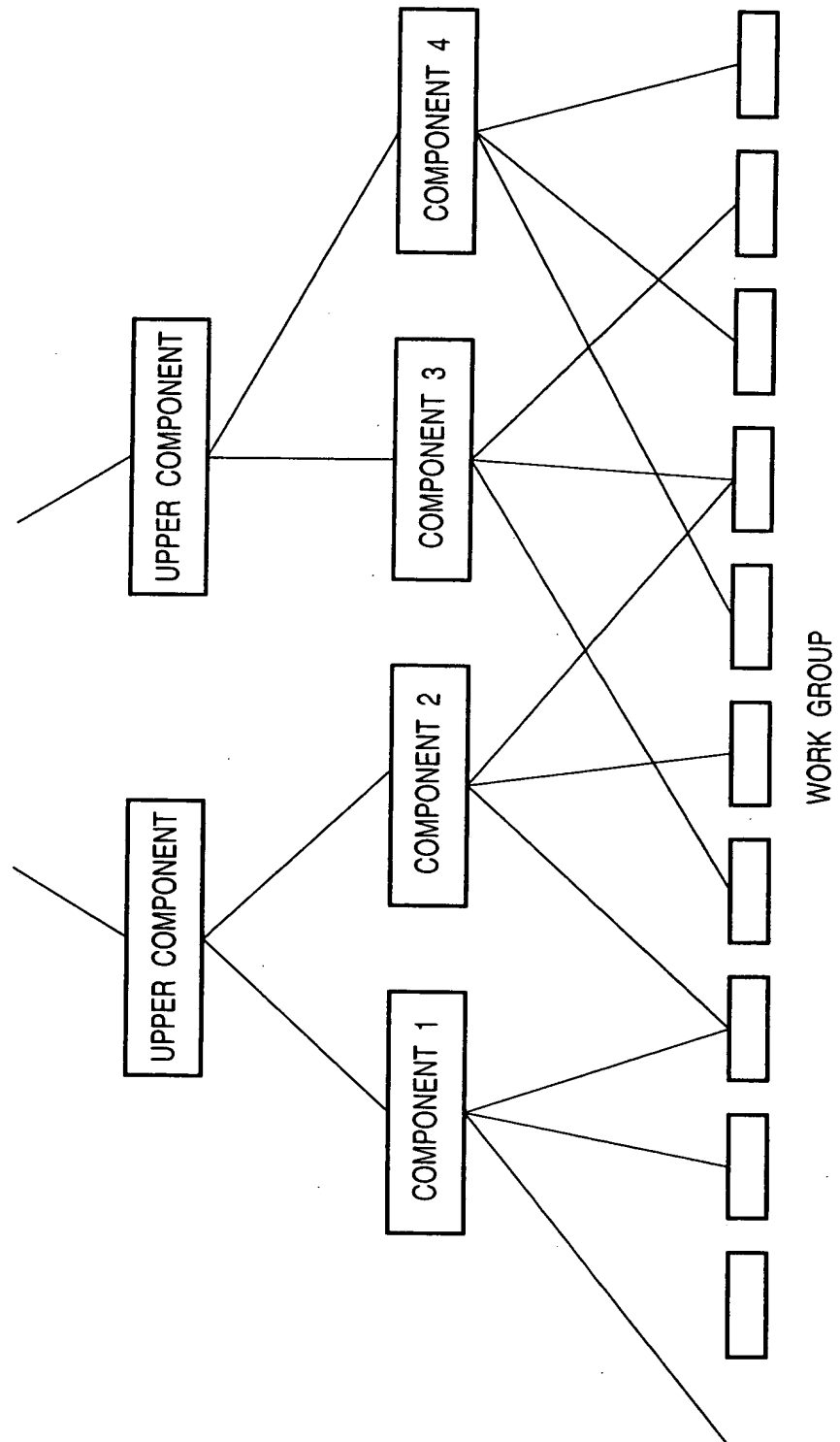


FIG. 50

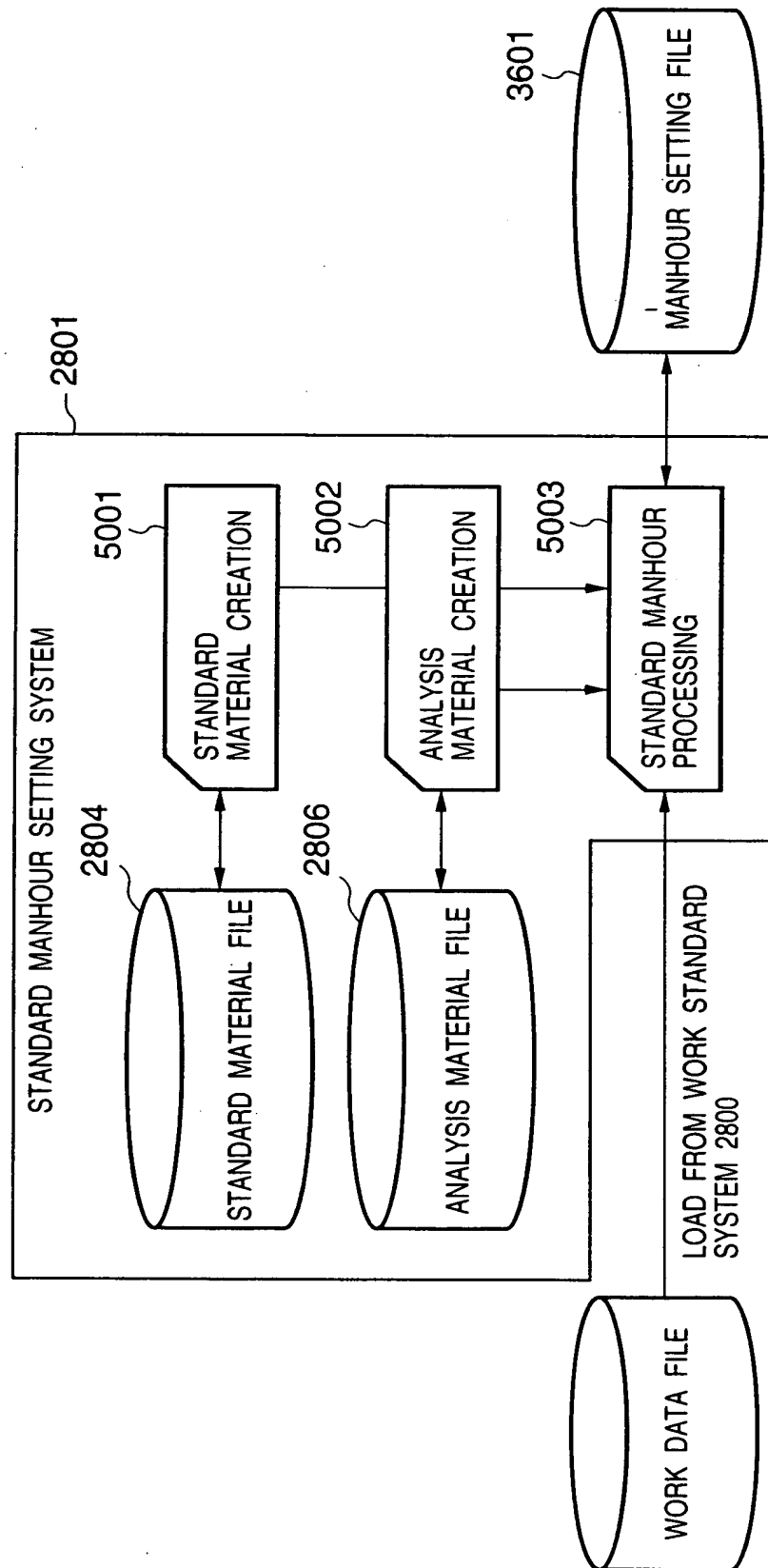
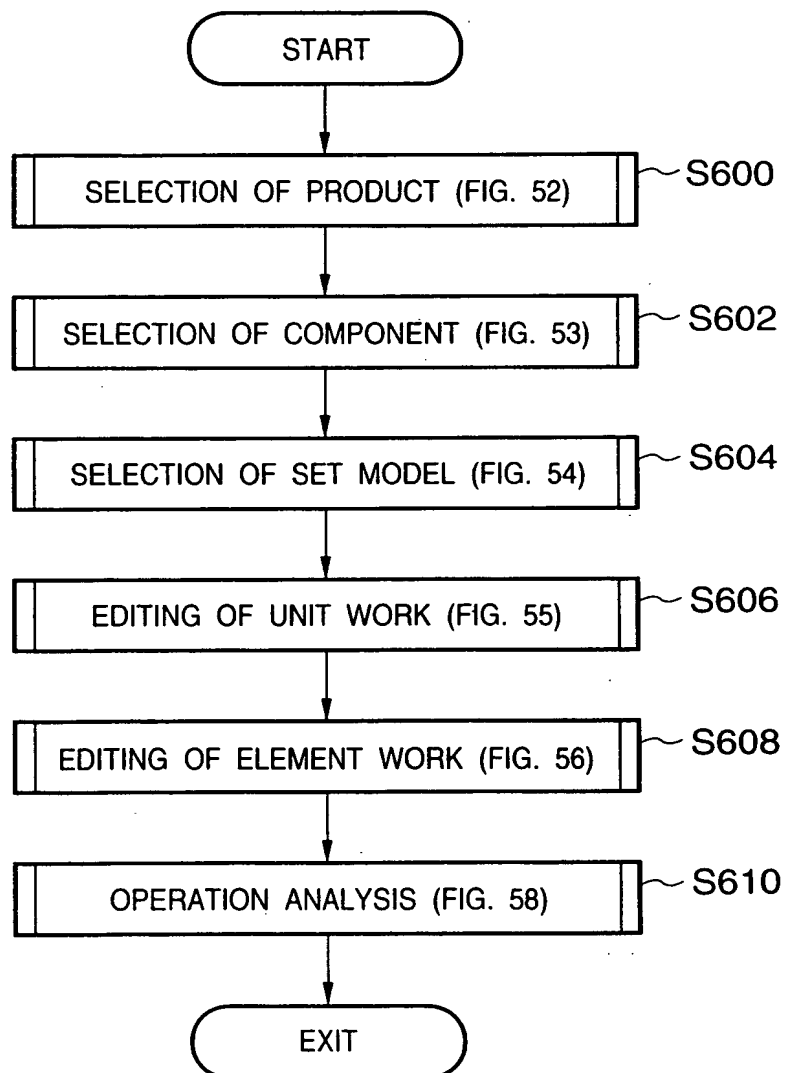


FIG. 51

5201

5301

5401

5501 5507 5506 5502 5503 5504 5505

								
---	---	---	---	---	---	---	---	---

NO.	ELEMENT WORK NAME.	REVISION	MANHOUR	US	CS	SET CONDITION
1	SET DOUBLE GEAR TO OPPOSITE SIDE OF AXIS IN ORDER OF SMALL GEAR DIAMETER	1	0	0	0	
*						

5604

FIG. 57

57/97

EDITING OF ANALYSIS MATERIAL

FILE(E) EDIT(E) VIEW(V)

PRODUCT GENRE :

ALL

TYPE/COMMENT 1	OBJECT	COMMENT 2	VERB	ANALYSIS SYMBOL	MANHOUR	USEFREQ.	COUNT	SET DATE
▲	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/G1/N>6/-3	15	0 1 1	0 97/09/09 9:52
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/E/02/N/-6	11	0 1 1	0 97/09/09 9:53
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/G1/N>6/-3	15	0 1 1	0 97/09/09 9:55
		ELEMENT WORK 01		VERB	-50/G1/N>6/-3	15	0 1 1	0 97/09/09 16:34
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/G1/N>6/-3	15	0 1 1	0 97/09/09 19:09
		CARRIAGE LOCK		APPLY	Time100/Rate100	100	100 1 1	1 97/09/09 19:16
	ASSEMBLE MOTOR	PRINTER CHASSIS		INSERT & SET	M211/1/10	50	1 1 1	1 97/09/09 17:00
		PRINTER CHASSIS		TURN INSIDE OUT	T1221/M2311/0/0	12	0 1 1	0 97/09/09 17:34
	1		1		T2221/M1211/0/1	24	0 1 1	0 97/09/09 17:20
	2		2		T1221/M2311/0/0	12	0 1 1	0 97/09/09 17:24
	PRINTER CHASSIS	ASSEMBLE PR GUIDE	SET			15	0 1 1	0 97/09/09 11:24
	dgdftafdfas		fdasfdasfasfad	*		16	0 1 1	0 97/09/09 12:10
	dsdsfisdaf		fdasfdsdids	T21121/M111/0/1		13	0 1 1	0 97/09/09 12:10
	dgdftafdfas		fdasfdasfasfad	*		16	0 1 1	0 97/09/09 13:39
	PRINTER CHASSIS	ASSEMBLE PR GUIDE	SET			15	0 1 1	0 97/09/09 14:00
	PRINTER CHASSIS	ASSEMBLE PR GUIDE	SET			15	0 1 1	0 97/09/09 14:00
	PRINTER UNIT		SET	Time100/Rate100		100	100 1 1	0 97/09/09 14:04

FIG. 58

OPERATION ANALYSIS									
<div> <div> </div> </div>		1 SET MAIN BODY TO PREDETERMINED POSITION		TOTAL SIMO VALUE : 0		TOTAL MANHOURLY VALUE : 15		SIMO NEXT ELEMENT WORK	
NO.	CONTENTS OF OPERATION			WF/OS	SET CONDITION	MANHOURLY	USE	REMARKS	
▲ 1	XXXXXX			PU	-60/Gr1/N/>6/-3	15	0		
*									

FIG. 59

5901

<input type="radio"/> 1. PU	<input type="radio"/> 6. DSY	<input type="radio"/> 11. PU	<input type="radio"/> 16. DSY
<input type="radio"/> 2. GET	<input type="radio"/> 7. R	<input type="radio"/> 12. GET	<input type="radio"/> 17. R
<input type="radio"/> 3. M	<input type="radio"/> 8. UMAC	<input type="radio"/> 13. M	
<input type="radio"/> 4. MA	<input type="radio"/> 9. MP	<input type="radio"/> 14. MA	
<input type="radio"/> 5. ASY	<input type="radio"/> 10. BODY	<input type="radio"/> 15. ASY	

☐ SIMO

5902

FIG. 60

XXXXXXX

PU

PICK UP

MANUAL

1 :	MOVING DISTANCE	1	-10cm	2	+10cm	3	>50cm	4	5	6
2 :	GRIP TYPE		Qr-3		Qr-2					
3 :	PRE-POSITIONING		NO		YES					
4 :	MAIN SIZE		-10mm		-6mm					
5 :	WEIGHT		<3Kg		>3Kg					
6 :										

SET

CANCEL

SET VALUE

FORMULA

6001

6002

6003

FIG. 61

FORMULA

TURN CHANGE DIRECTION OF BODY MANUAL

FORMULA : 10 * m

VARIABLE	VARIABLE NAME	VALUE	UNIT
m :	THE NUMBER OF TIMES OF OPERATION OF CHANGING DIRECTION		COUNT

6101 6104 6103

6102 6105

SET CANCEL SET VALUE

FIG. 62

The figure shows a graphical user interface window titled "INQUIRY OF LOG". The window contains several input fields and two buttons at the bottom. The fields are labeled as follows:

- 6201**: Points to the title bar of the window.
- 6202**: Points to the "VARIATION AMOUNT" input field, which contains the value "10".
- 6203**: Points to the "USE" input field, which contains the value "0".
- 6204**: Points to the "REASON CODE" input field, which contains the value "1".
- 6205**: Points to the "OK" button.
- 6206**: Points to the "Clear" button.

There is also a "CHANGE REASON" field containing a dropdown menu with the text "SET" and a downward arrow icon.

FIG. 63

6301 6302

CORRECTION OF CHANGE LOG

DATE

1997

09

22

○ =

○ FROM

○ BEFORE

○ ~

SEARCH

NO.	UNIT WORK NAME	CODE	CHANGE REASON	NEW MANHOUR	(NEW) MANUAL	(NEW) USE	PREVIOUS (PREVIOUS) MANHOUR	(PREVIOUS) USE	CHANGE DATE
▶ CH-01-01	ELECTRICAL CHECK	1	SET	10	10	0	0	0	1997/09/22 14:30.00

REASON CODE

1

CHANGE REASON

SET

OK

CIR

END

FIG. 64

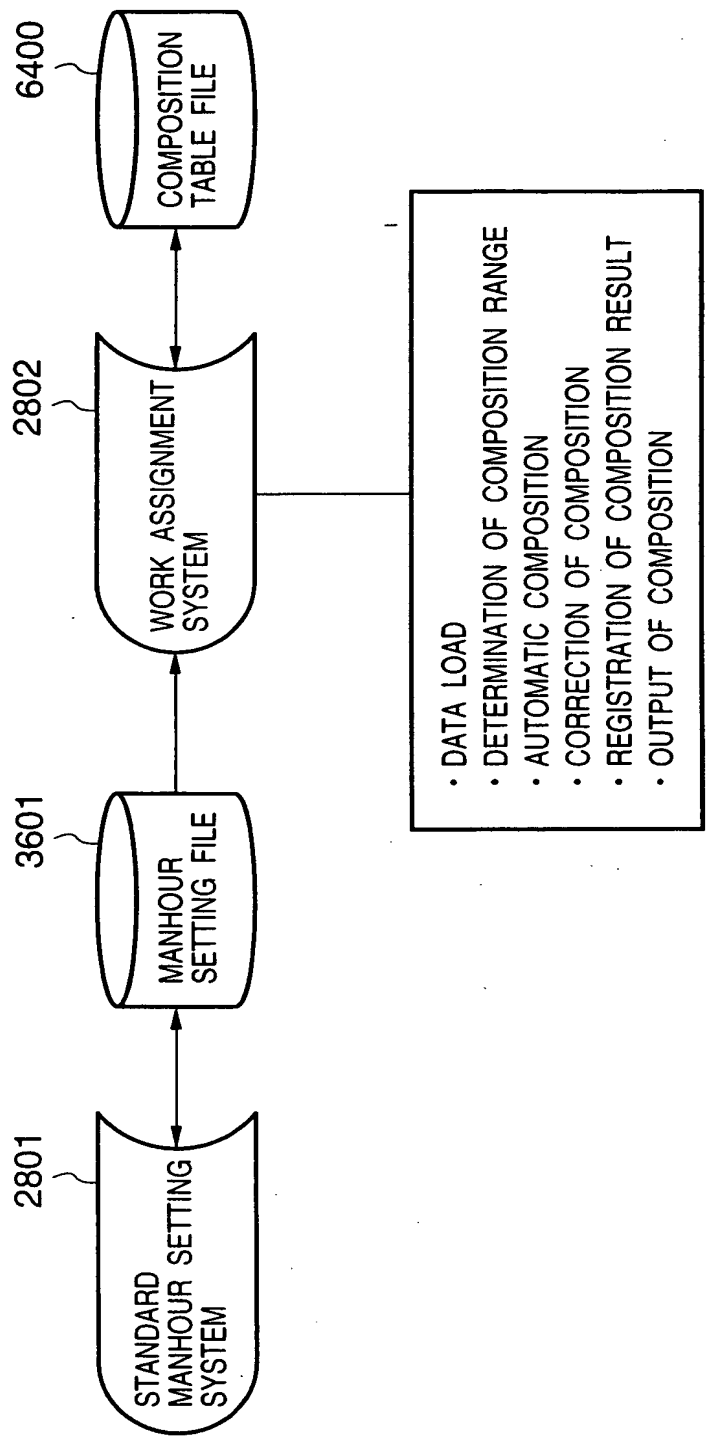


FIG. 65

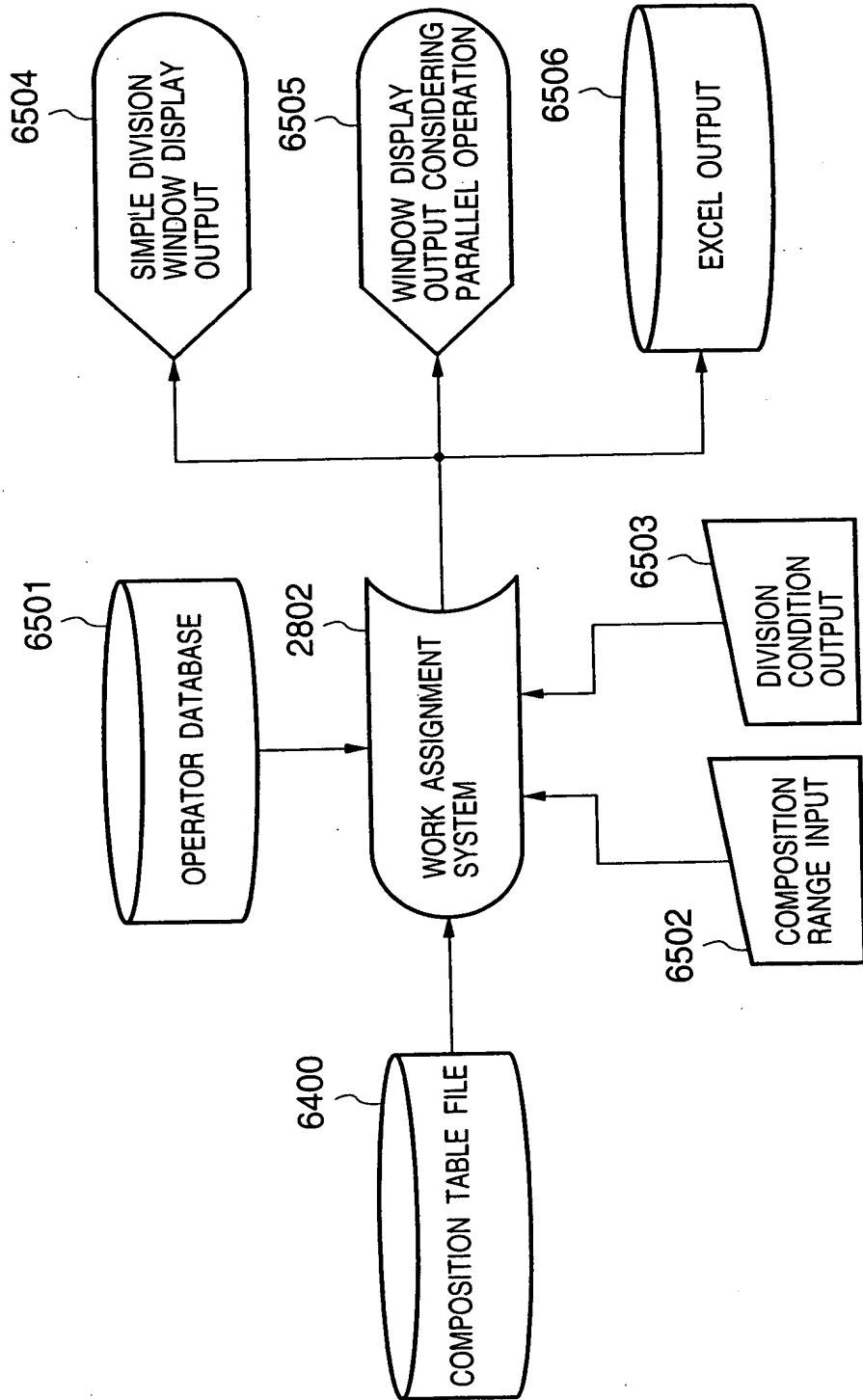


FIG. 66

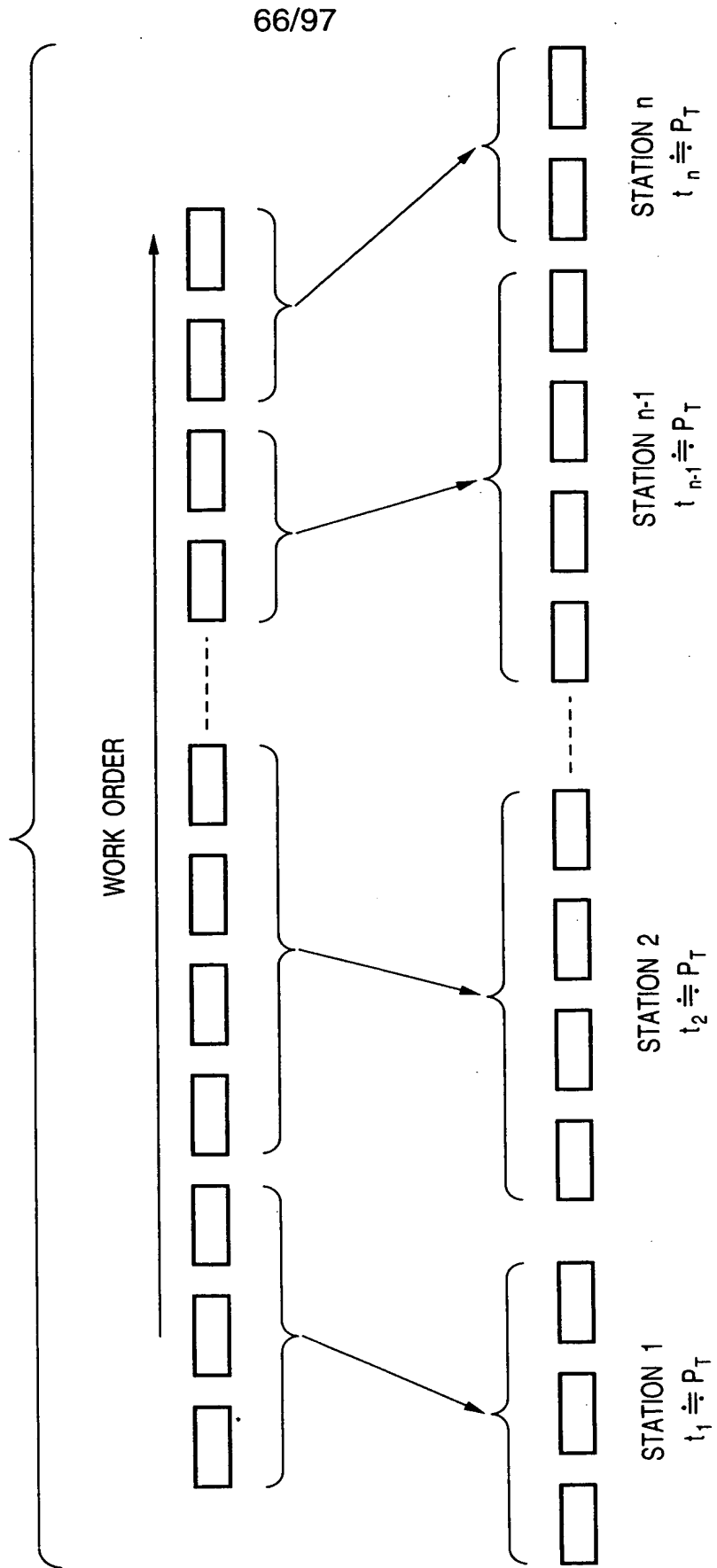


FIG. 67

		▼	▲
FILE(F) EDIT(E) INPUT(I) TOOL(O)			

MODEL

GP55

UNIT

STANDARD NO.	WORK NAME	MANHOUR
0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0003	WEIMAN REMOVAL	270
0004	ASSEMBLE OUTER CASE	365
0005	FIT TOP PAD	268
0006	STICK LARGE-SIDE ORDER LABEL	117

⋮

SIMPLE DIVISION
PARALLEL DIVISION

FIG. 68

SIMPLE DIVISION

		▼	▲
	FILE(F) EDIT(E)		◆
St 1			
0001	STICK HANDY CUT TAPE	134	
0002	SET LABELS ON MAIN BODY	550	
0003	WEIMAN REMOVAL	270	
St 2			
0004	ASSEMBLE OUTER CASE	365	
0005	FIT TOP PAD	268	
0006	STICK LARGE-SIDE ORDER LABEL	117	
⋮			

FIG. 69

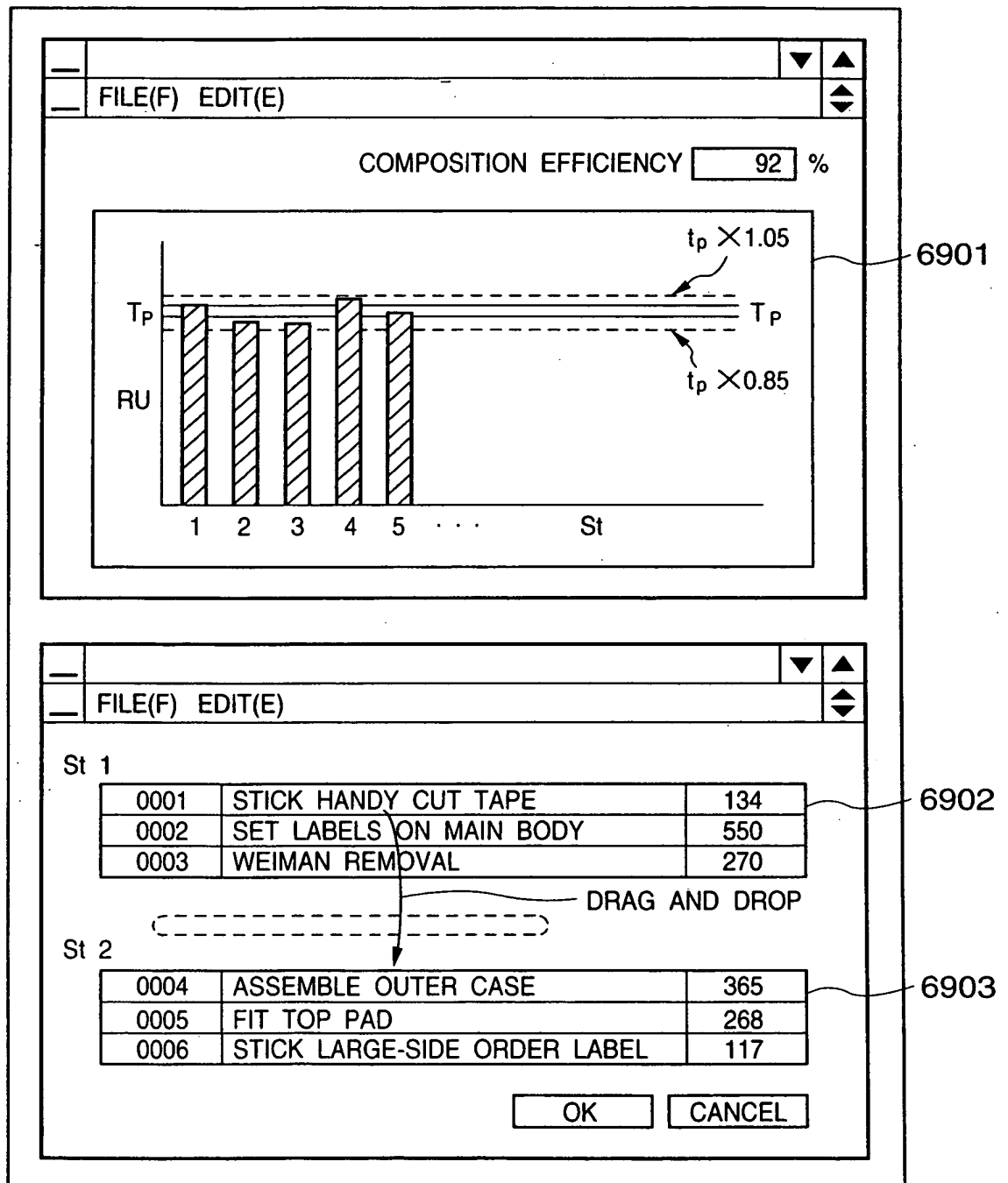


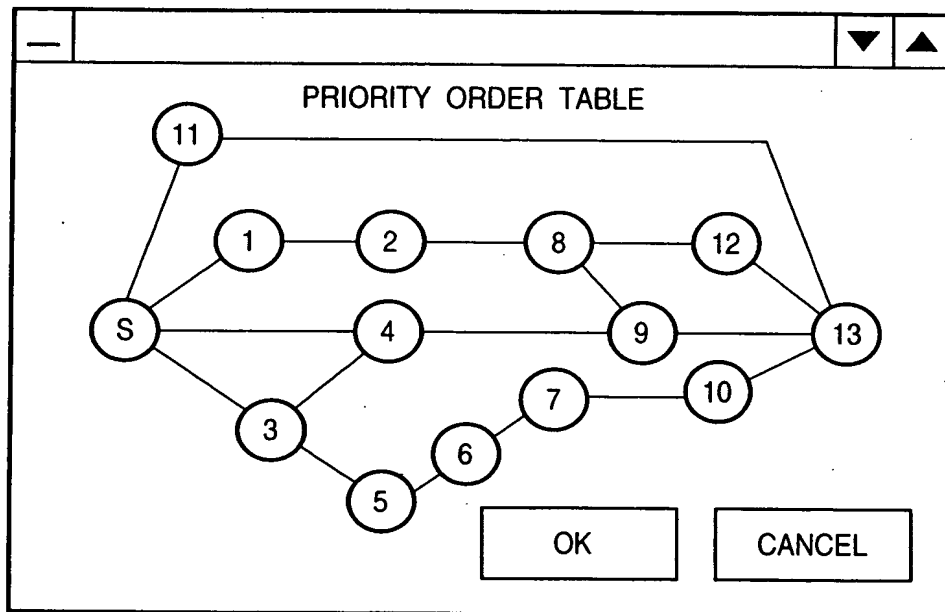
FIG. 70

FIG. 71

PARALLEL DIVISION

				▼	▲
PLAN 2		PLAN 1			
St 1		St 1			
1		1	STICK HANDY CUT TAPE	99	
2		2	SET LABELS ON MAIN BODY	78	
8		3	WEIMAN REMOVAL	134	
St 2		St 2			
3		4	ASSEMBLE OUTER CASE	732	
4		5	FIT TOP PAD	268	
5		6	STICK LARGE-SIDE ORDER LABEL	117	
		⋮			

FIG. 72

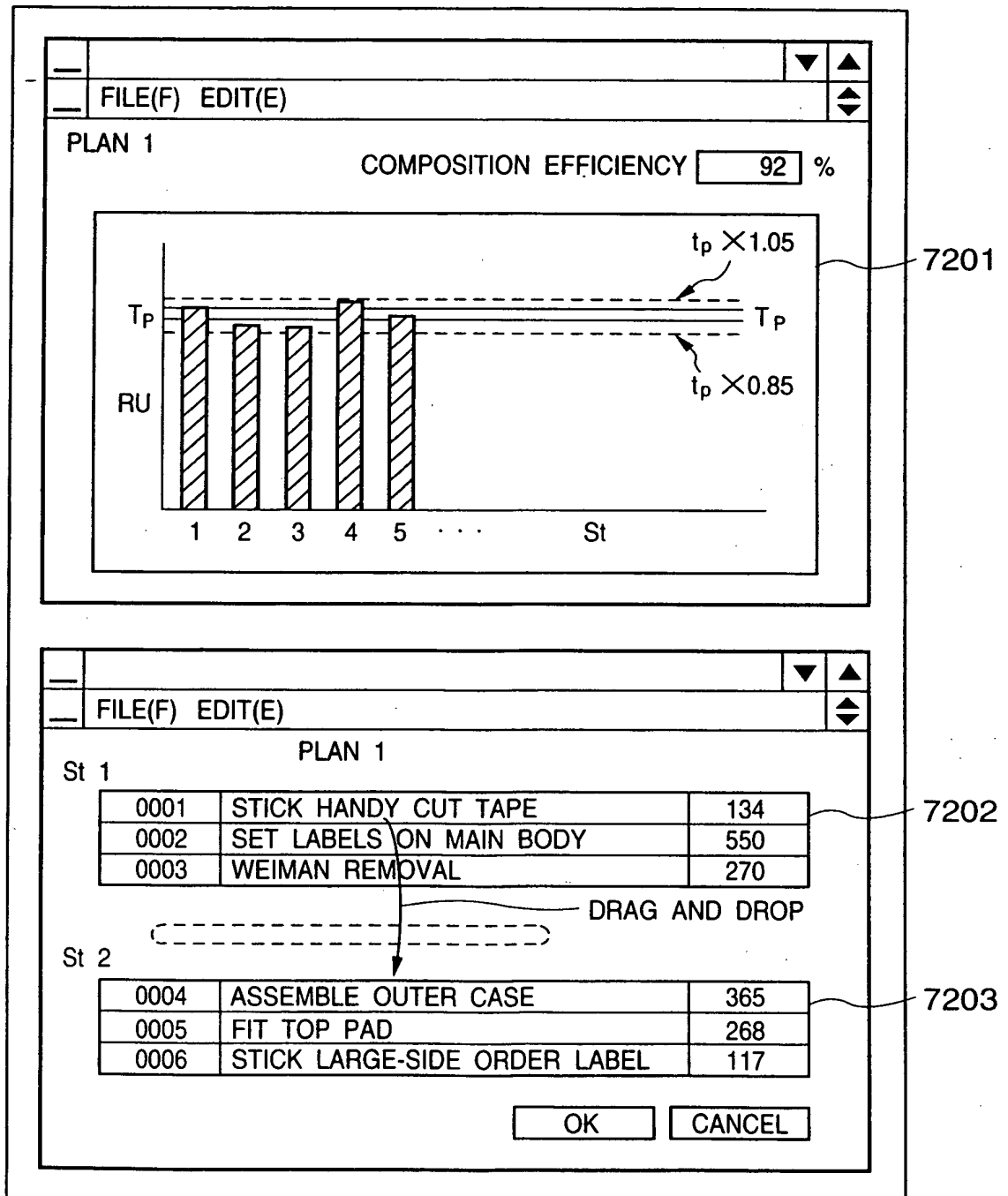


FIG. 73

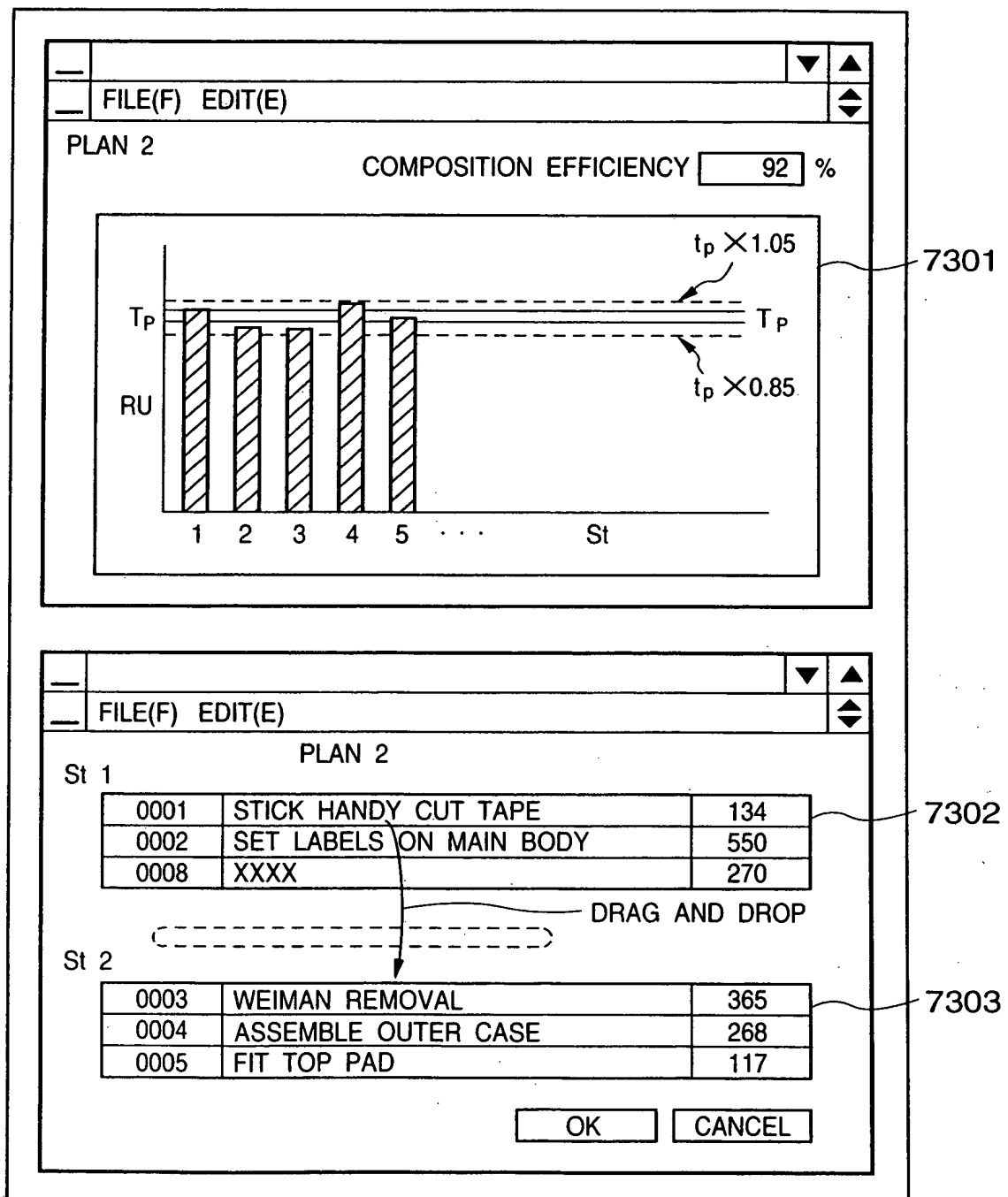


FIG. 74

74/97

LOAD OF NEWLY COMPOSED DATA (MANHOURL)

7401

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7408

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FIG. 75

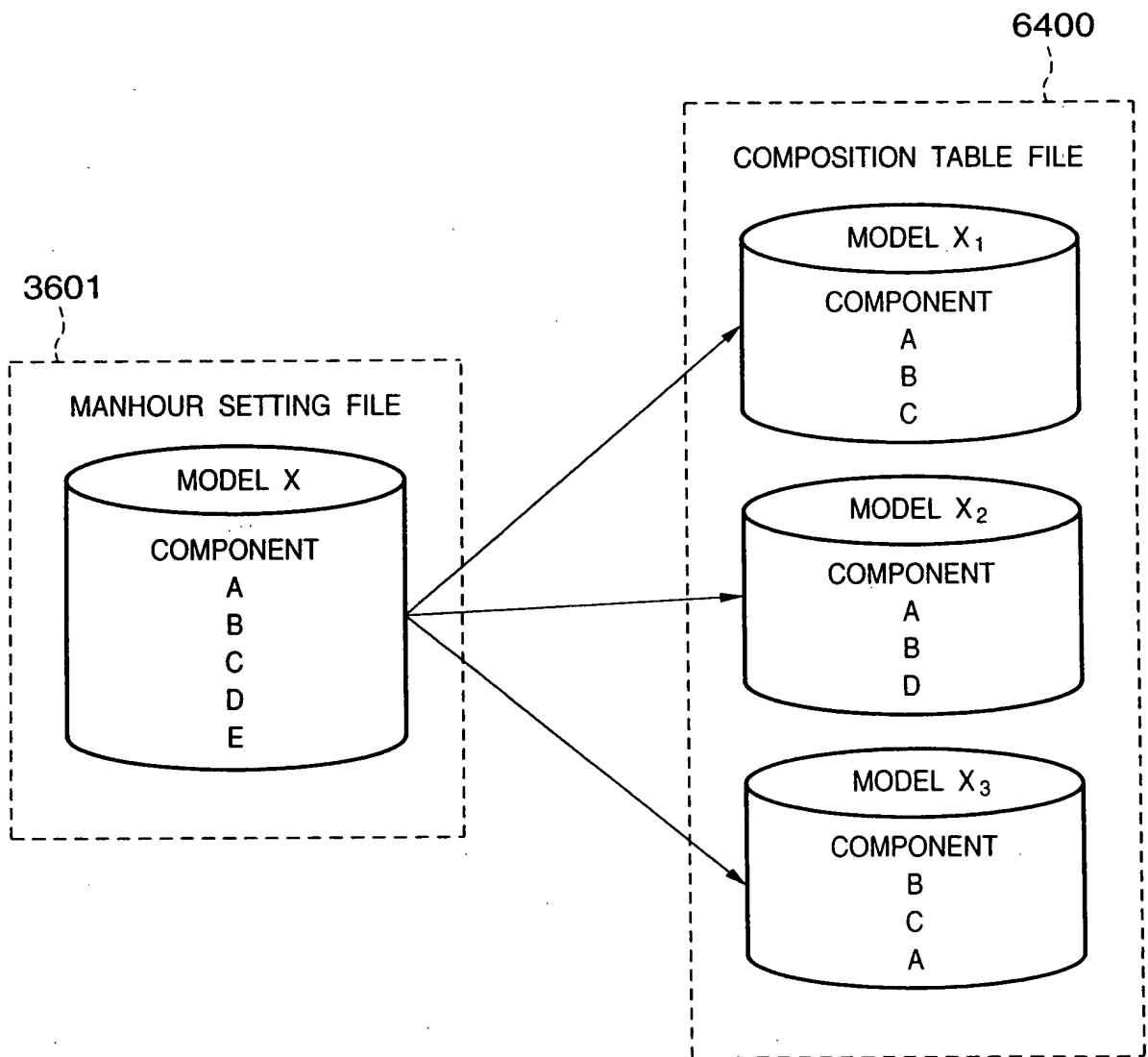


FIG. 76

7601

7602

7603

7604

7606

76/97

OPEN FILE

TARGET MODEL

NAME

REVISION NUMBER

SAVE DATE

f12-0010.csv

TEST DATA (ORIGINAL)

1

97/09/19 12:00:34

f12-0010.csv

TEST

0

97/09/19 13:27:17

BJC-4300

0

97/09/19 14:10:14

BJC-4300

0

97/09/19 14:10:32

BJC-4300

1

97/09/19 15:41:14

BJC-4300

BJC-4300A LINE FORMATION

97/09/20 14:16:36

BJC-4300

BJC-4300A LINE FORMATION

03

97/10/13 17:54:57

BJC-4300

BJC-4300A LINE FORMATION

00

97/09/20 14:06:36

f12-0010.csv

BJC-4300A LINE FORMATION

05

97/09/24 17:11:53

SELECT WINDOW

○ COMPOSITION DATA INPUT WINDOW

○ COMPOSITOR DATA CORRECTION WINDOW

OK

CANCEL

FIG. 77

[illegible]

FIG. 78

INSERTION OF UNIT WORK ✕

NEW WORK WILL BE INSERTED BEFORE
"STICK CHECK SHEET SERIAL NO."

INPUT WORK NAME AND PROVISIONAL MANHOUR VALUE

UNIT WORK NAME :

PROVISIONAL MANHOUR : (RU)

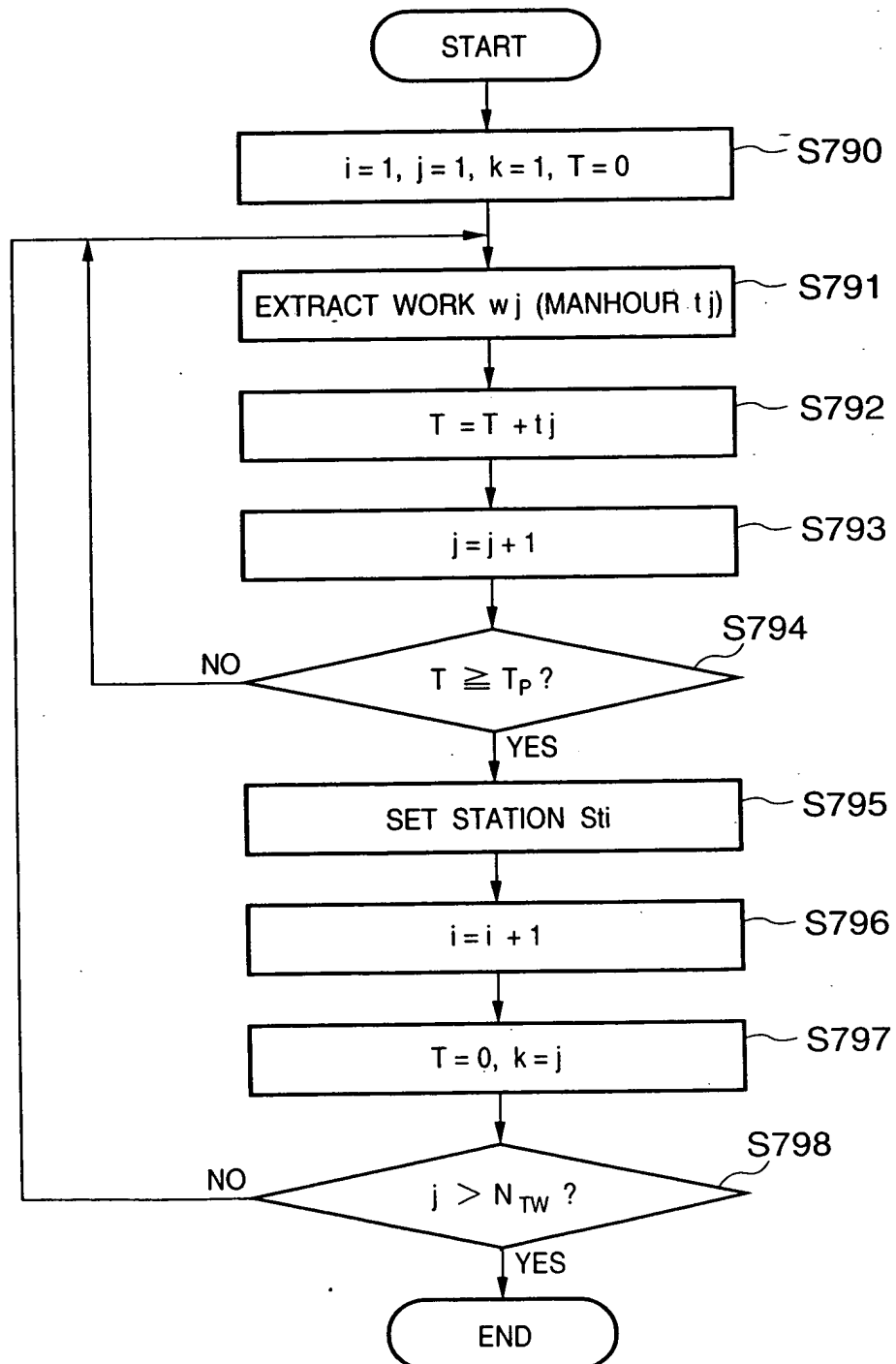
REMARKS :

OK CANCEL

7801

7802

FIG. 79



8006

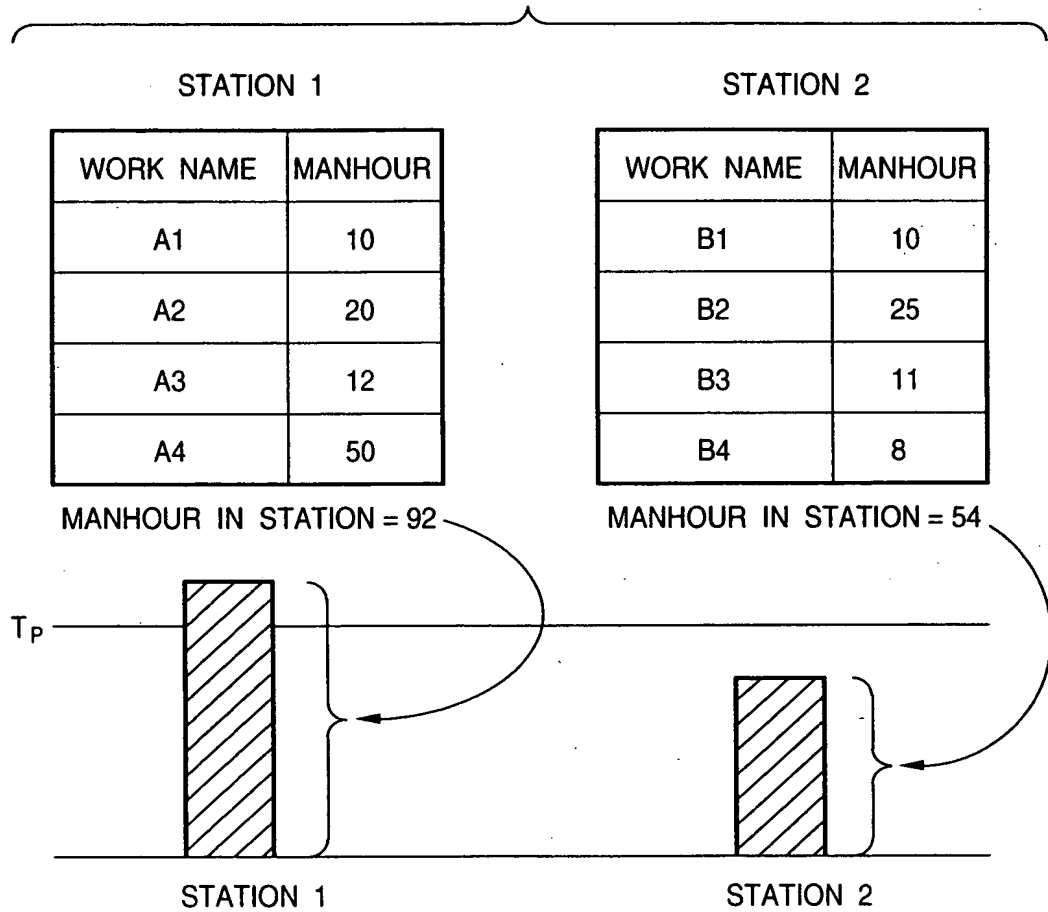
FIG. 81

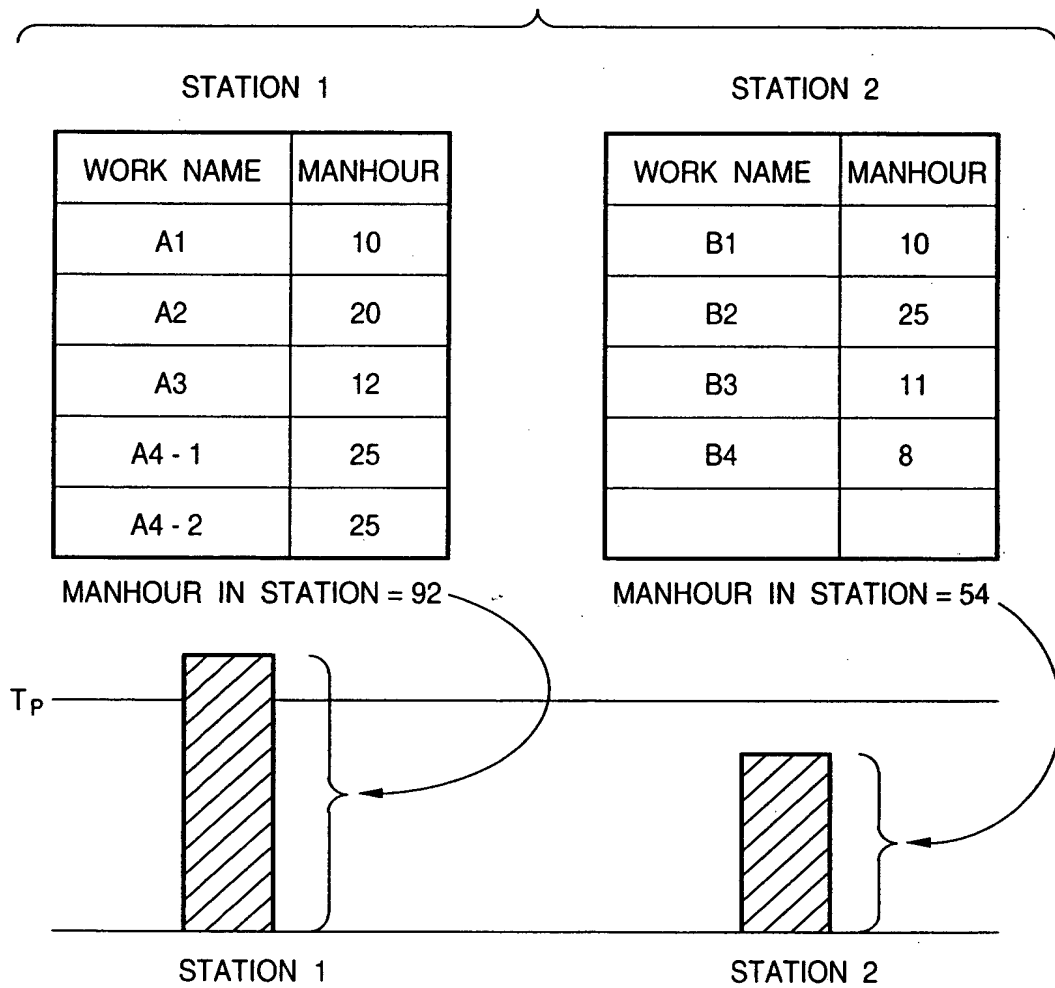
FIG. 82

FIG. 83

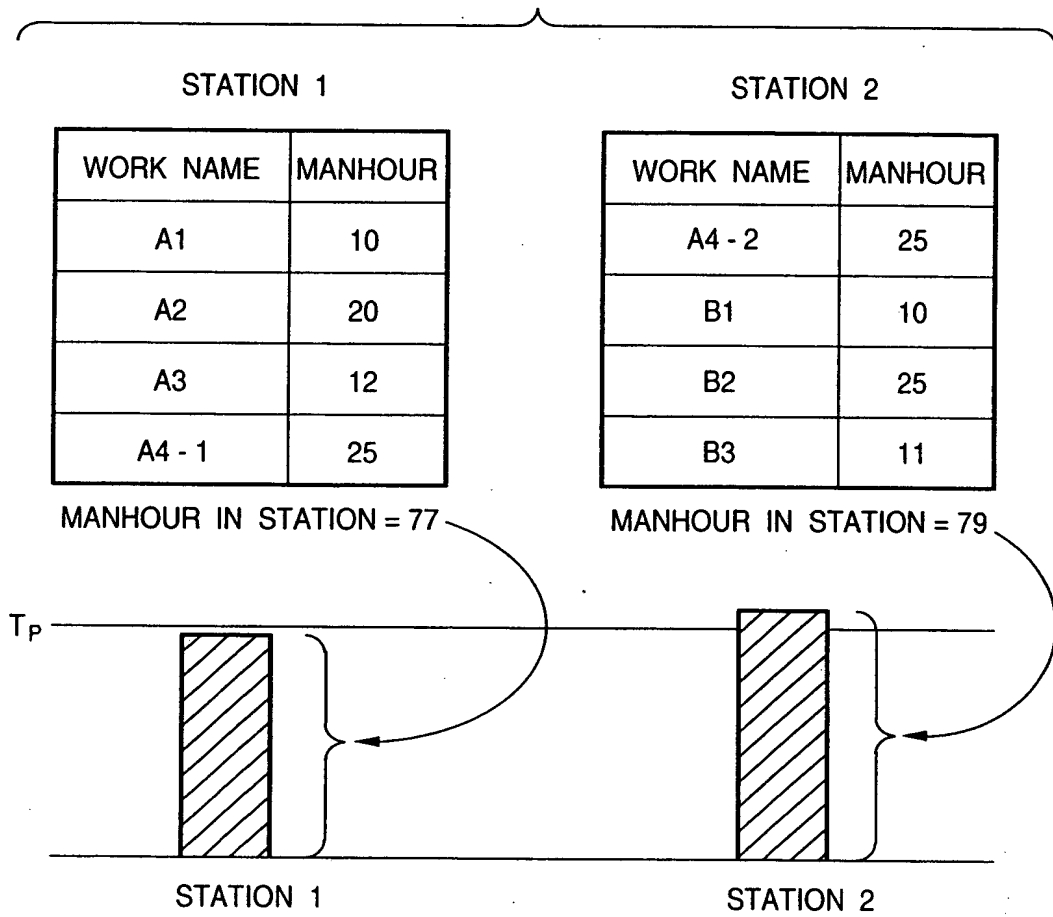


FIG. 84

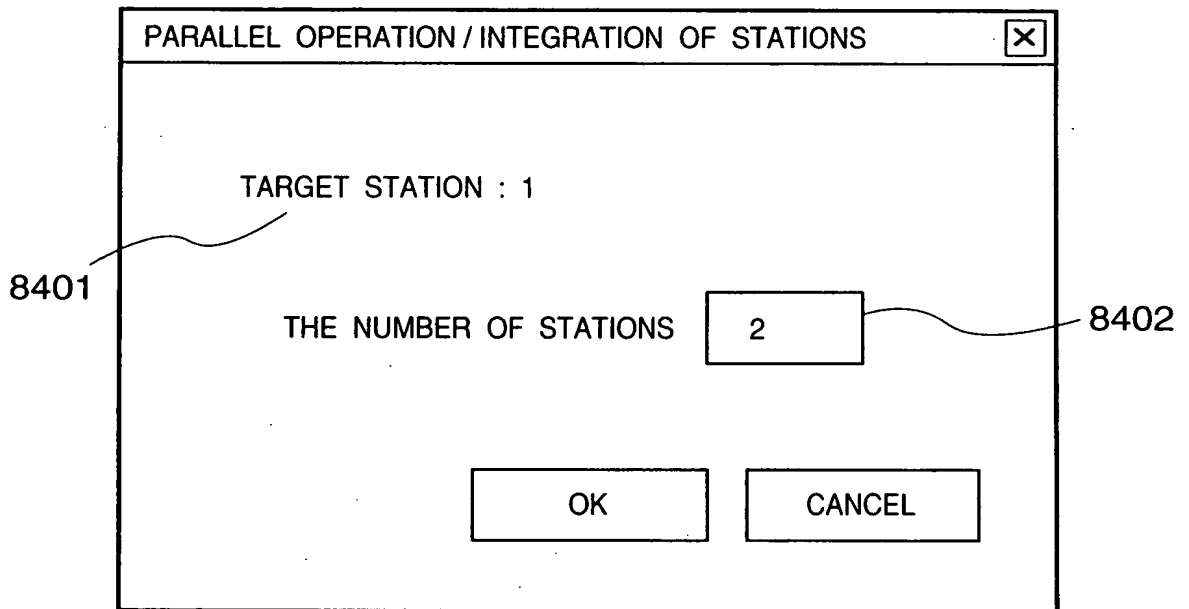


FIG. 85

FILE(F) EDIT(E) VIEW(V) TOOL(T)

OPERATOR 1

SI1

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE	MAN-UAL
START	0	0	No.	No.
UNIT WORK NAME 1	34	10	No.01	
UNIT WORK NAME 2	255	46	No.02	
UNIT WORK NAME 6	92	26	No.06	
UNIT WORK NAME 7	52	0	No.07	
UNIT WORK NAME 8	52	0	No.08	
UNIT WORK NAME 9	0	36	No.09	

TOTAL 585 (RU)

PF 83.6%

OPERATOR 2

SI2

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE	MAN-UAL
UNIT WORK NAME 3	156	0	No.03	
UNIT WORK NAME 4	34	0	No.04	
UNIT WORK NAME 5	138	23	No.06	
UNIT WORK NAME 10	71	48	No.10	
UNIT WORK NAME 11	138	30	No.11	
UNIT WORK NAME 12	97	20	No.12	
UNIT WORK NAME 13	88	0	No.14	
UNIT WORK NAME 14	46	18	No.15	
UNIT WORK NAME 15	546	15	No.16	
UNIT WORK NAME 16	58	20	No.17	

TOTAL 1548 (RU) xxxxxx

PF 23.5 %

OPERATOR 3

SI3

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE	MAN-UAL
UNIT WORK NAME 13	30	40	No.13	
UNIT WORK NAME 16	303	131	No.18	

TOTAL 572 (RU)

PF 96.7%

OPERATOR 4

SI4

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE	MAN-UAL
UNIT WORK NAME 19	84	26	No.19	
UNIT WORK NAME 20	120	20	No.20	
UNIT WORK NAME 21	310	66	No.21	

TOTAL 623 (RU)

PF 95.2%

OPERATOR 5

SI5

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE	MAN-UAL
UNIT WORK NAME 22	146	71	No.22	
UNIT WORK NAME 23	106	26	No.23	
UNIT WORK NAME 24	61	0	No.24	
UNIT WORK NAME 25	51	10	No.25	
END	0	0	No.X	

TOTAL 486 (RU)

PF 73.6%

PARALLEL STATIONS

COMPOSITION MODE : PRIORITY ORDER SCHEME

COMPOSITION EFFICIENCY 116 %

NET COMPOSITION EFFICIENCY %

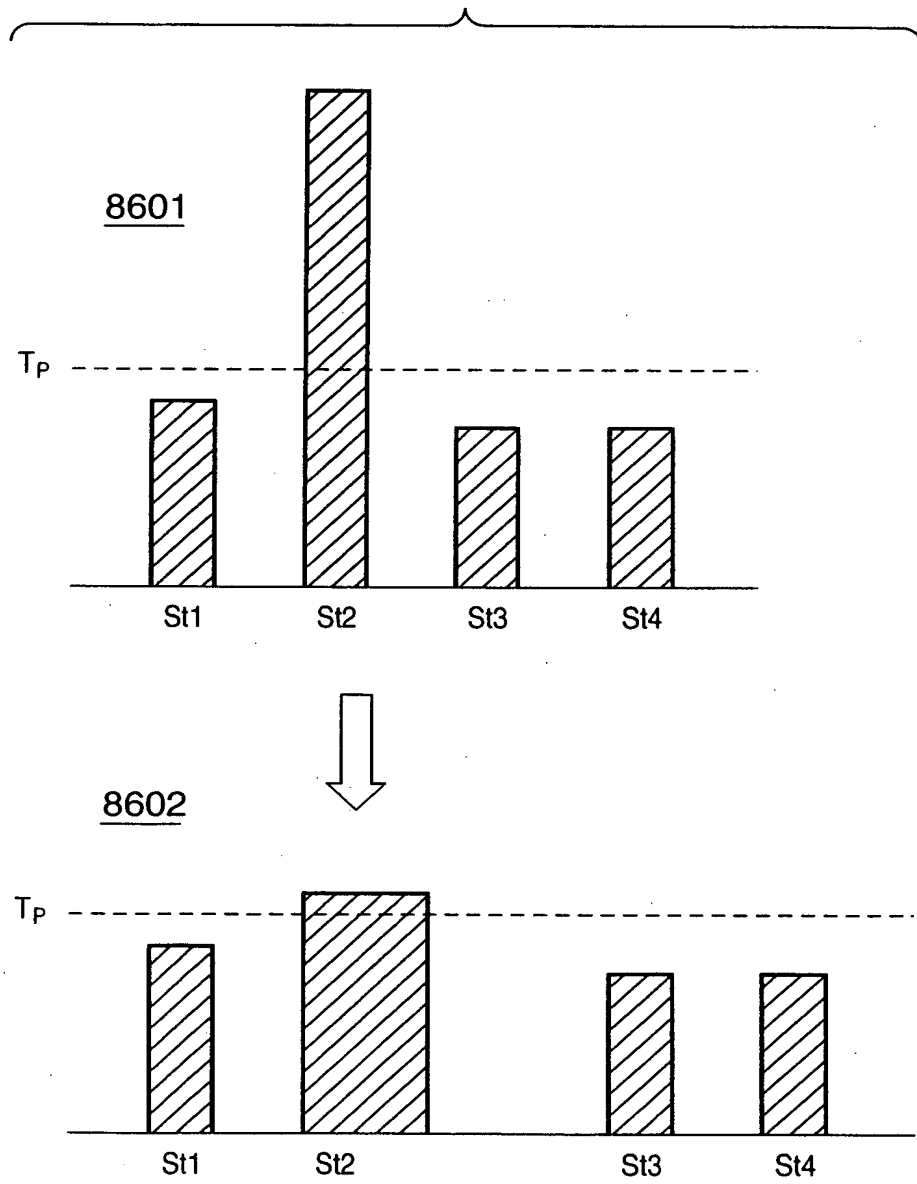
FIG. 86

FIG. 87

A diagram of a 'USER REGISTRATION' dialog box. The dialog box has a title bar with the text 'USER REGISTRATION' and a close button (X). Inside the dialog box, there are five input fields and two buttons. The fields are labeled as follows: 'NAME CODE :', 'NAME :', 'POSITION :', 'PASSWORD :', and 'AUTHORITY :'. The 'NAME CODE' field contains the text '12345'. The 'NAME' field is split into two sub-fields, 'TANAKA' and 'ICHIRO'. The 'POSITION' field contains the text 'kumitate' and has a dropdown arrow on the right. The 'PASSWORD' field contains the text '12345'. The 'AUTHORITY' field is empty. Below the fields are two buttons labeled 'OK' and 'CANCEL'. On the right side of the dialog box, there are five reference numbers (8701, 8702, 8703, 8704, 8705) with lines pointing to the respective input fields.

USER REGISTRATION [X]

NAME CODE : 12345 8701

NAME : TANAKA ICHIRO 8702

POSITION : kumitate 8703

PASSWORD : 12345 8704

AUTHORITY : 8705

OK CANCEL

FIG. 88

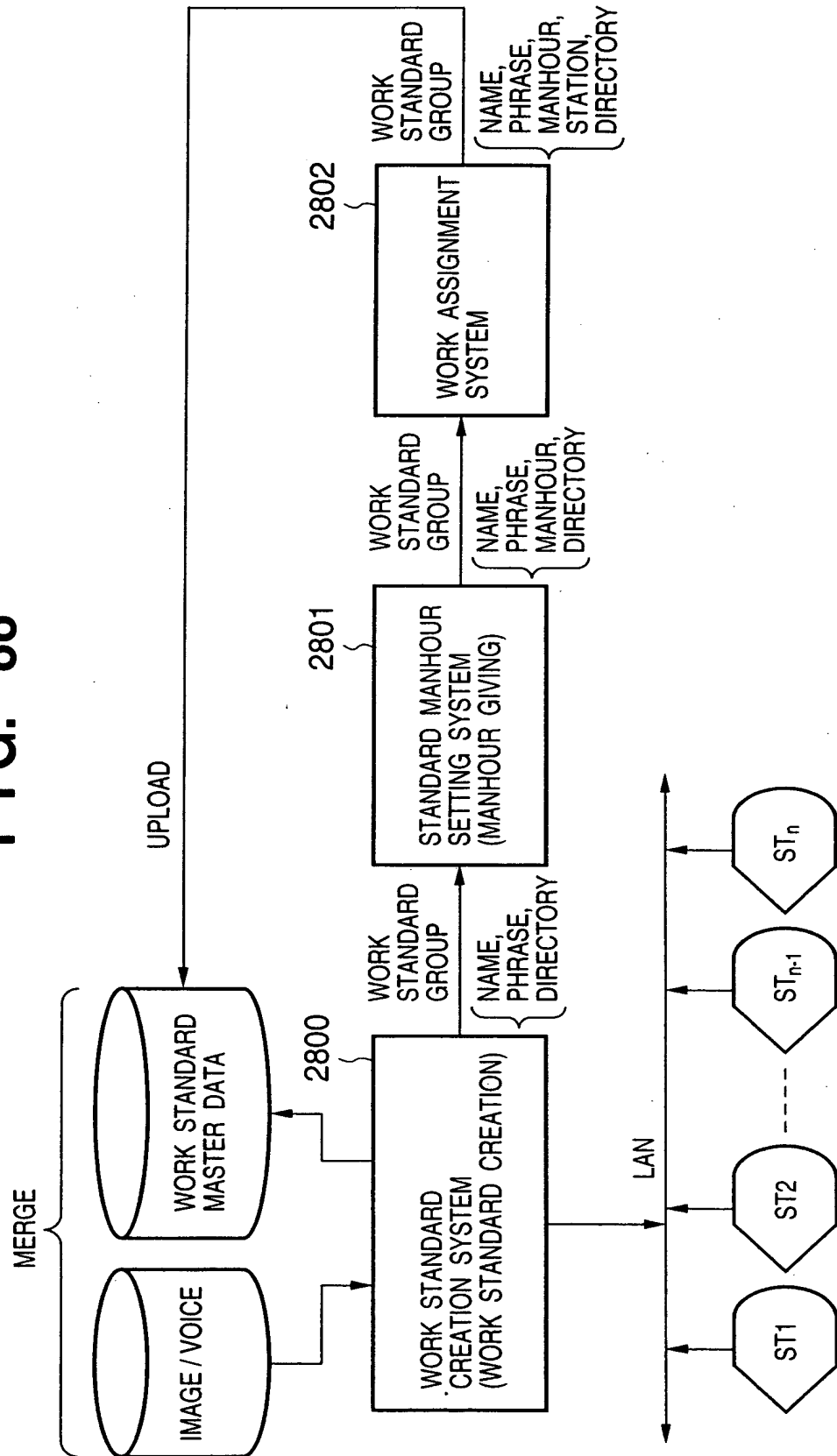


FIG. 89

DIRECTORY NAME	IMAGE DATA	OPERATION (VERB)	PARAMETER 1	PARAMETER 2	PARAMETER 3
xxxxx1	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 10mm	TORQUE 10Kg.M
xxxxx2	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 20Kg.M
xxxxx3	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 30Kg.M
...
yyyyy1	ROTATE	ROTATE	CLOCKWISE	DISTANCE MOVEMENT 20mm	
yyyyy2	ROTATE	ROTATE	COUNTERCLOCKWISE	DISTANCE MOVEMENT 20mm	
...
zzzzzz1	OPEN	OPEN	OPEN UPWARD	DISTANCE MOVEMENT 30mm	WEIGHT 100g
zzzzzz2	OPEN	OPEN	OPEN DOWNWARD	DISTANCE MOVEMENT 40mm	WEIGHT 200g
...

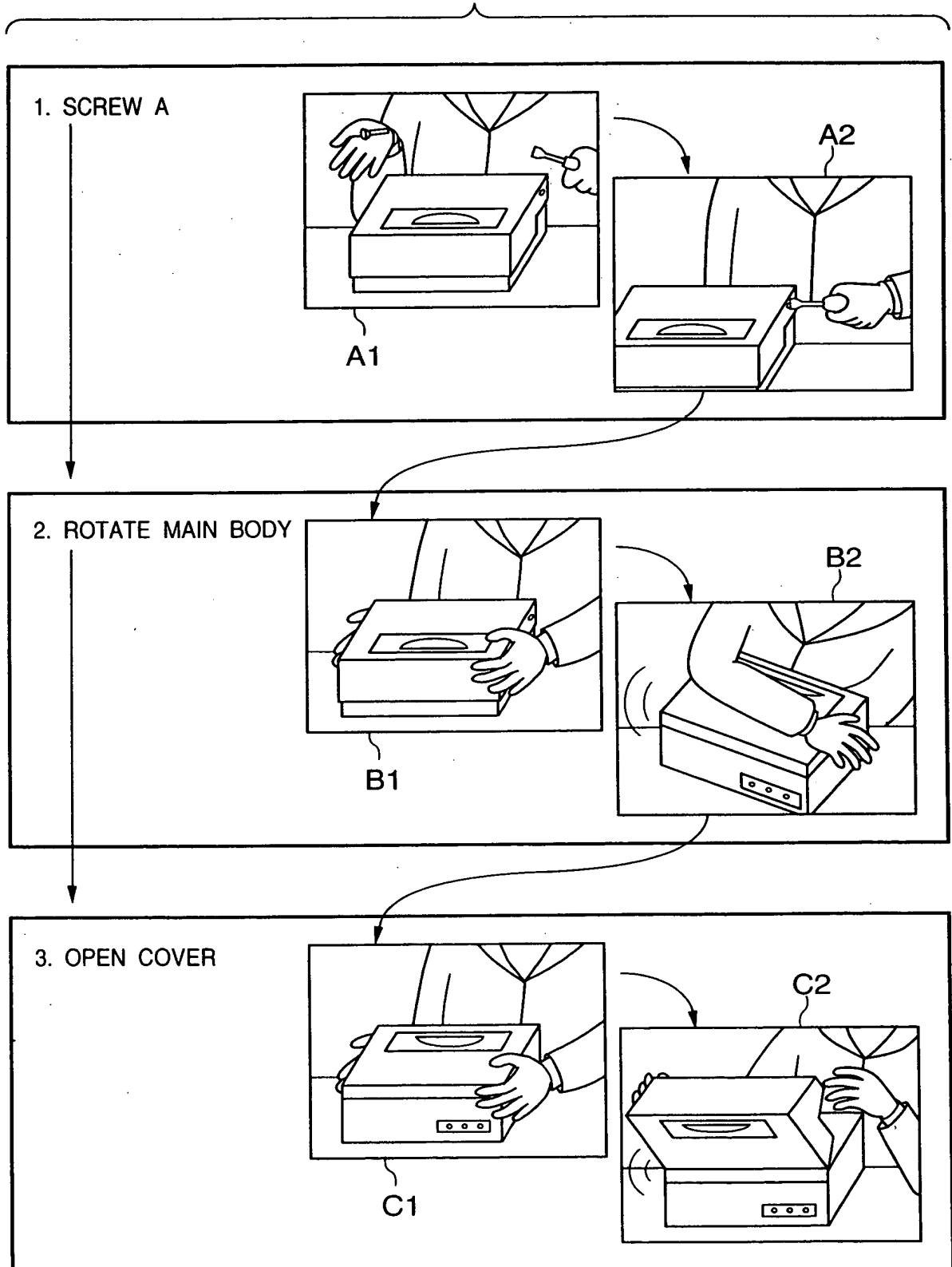
FIG. 90

FIG. 91

9101 9102

SETTING OF COMPONENT SYMBOL

PRODUCT SYMBOL : BJ-970909

COMPONENT SYMBOL : CH

COMPONENT NAME : CHECK

OK SEARCH COMPONENT CANCEL

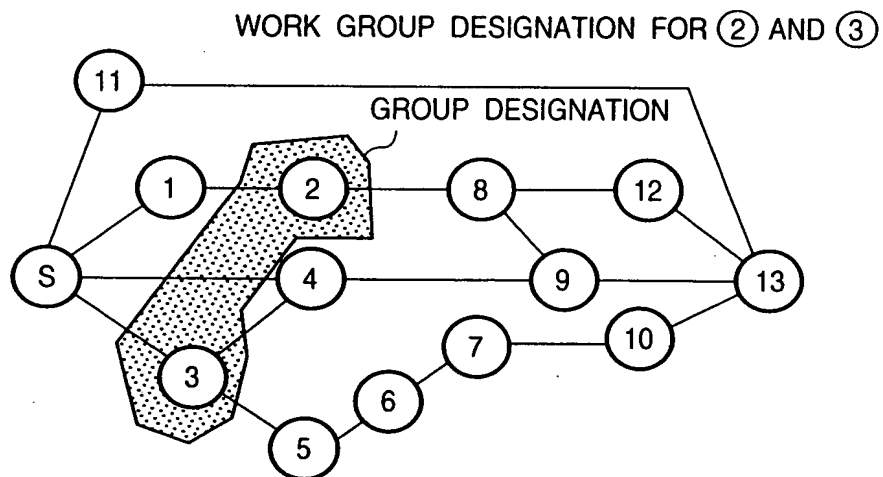
FIG. 92

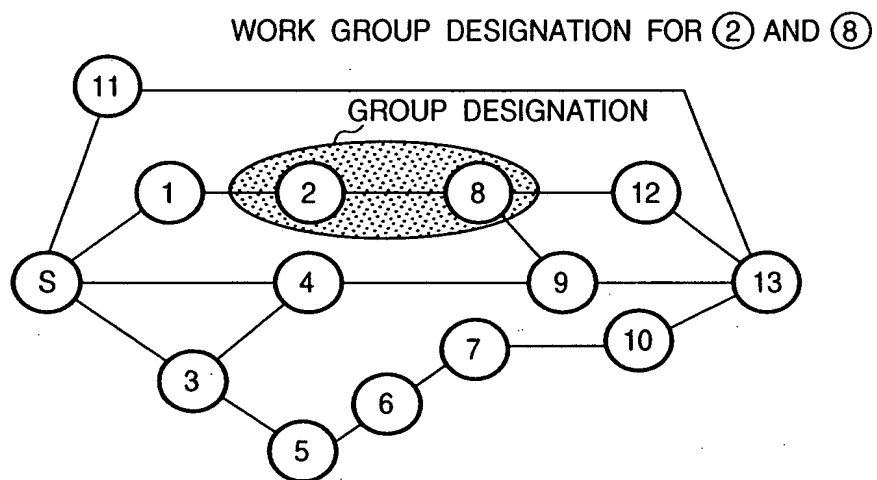
FIG. 93

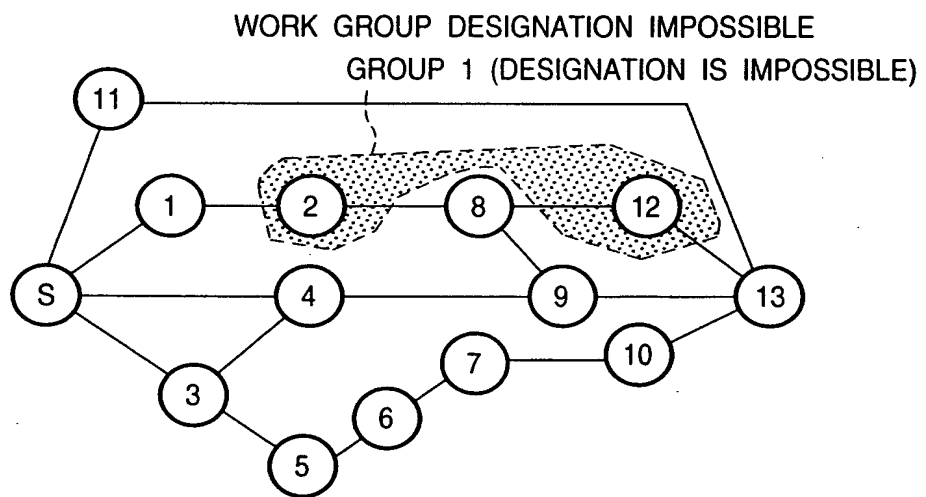
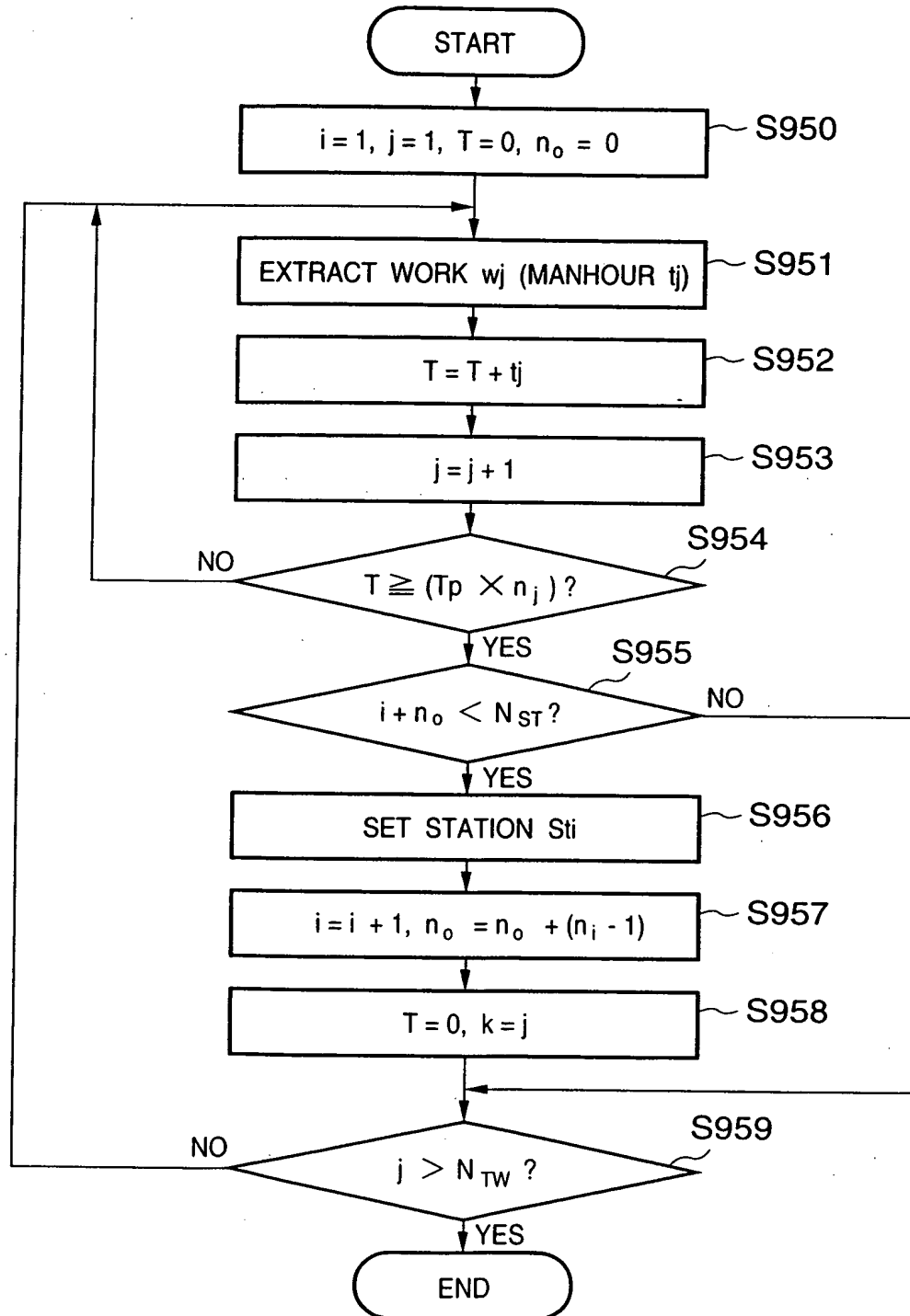
FIG. 94

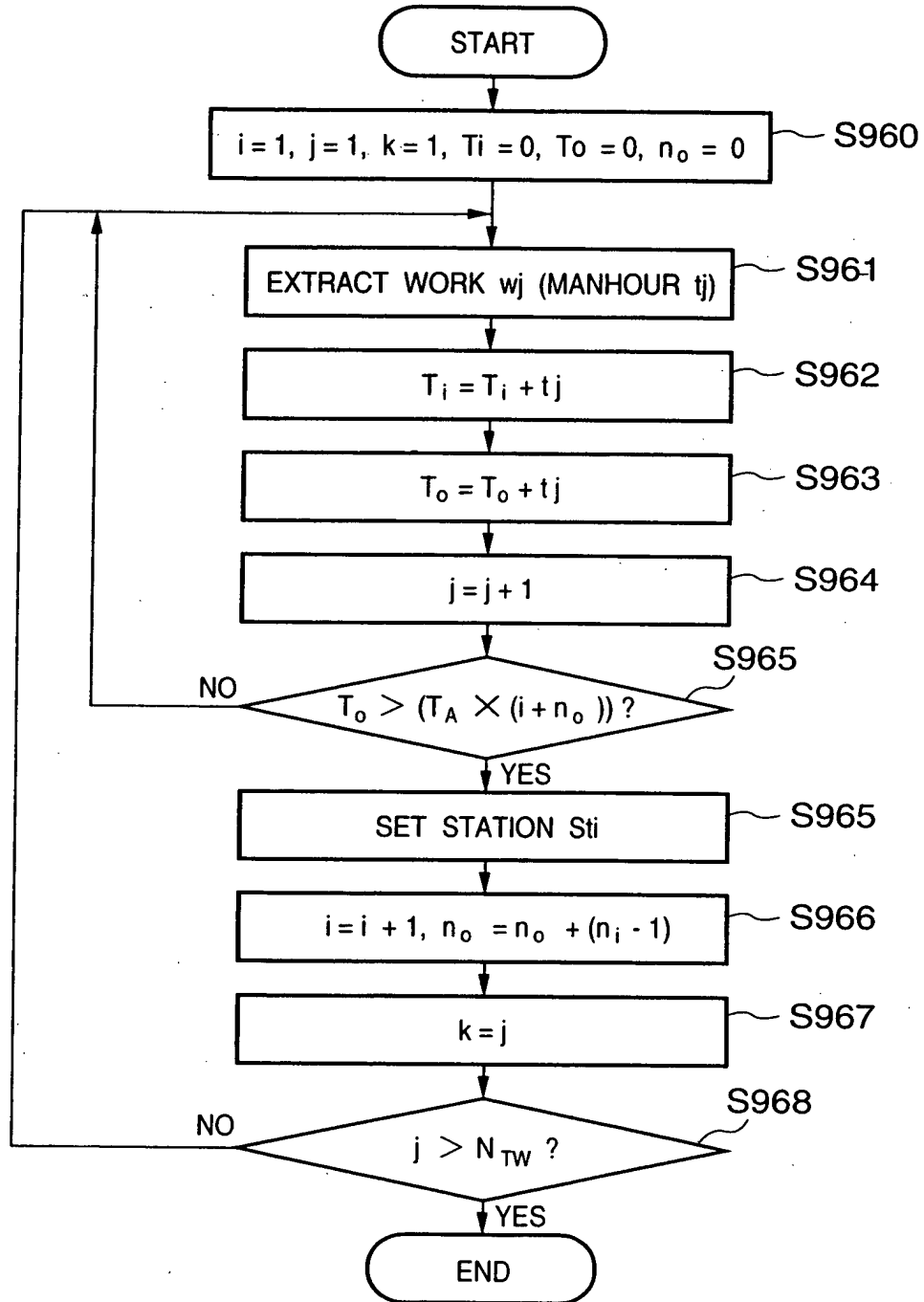
FIG. 95



N_{ST} : THE NUMBER OF STATIONS
 n_i : i STATION PARALLEL NUMBER
 n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

96/97

FIG. 96



N_{ST} : THE NUMBER OF STATIONS

T_i : i STATION MANHOUR

T_A : STATION MANHOUR AVERAGE VALUE

$T_A = WF / N_{ST}$

T_o : TOTAL ACCUMULATED MANHOUR

n_i : i STATION PARALLEL NUMBER

n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

FIG. 97

FILE(E) EDIT(E) VIEW(D) TOOL(T)

OPERATOR 1

S11

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
START	0	0	No.
UNIT WORK NAME 1	34	10	No.01
UNIT WORK NAME 2	255	46	No.02
UNIT WORK NAME 6	92	26	No.06
UNIT WORK NAME 7	52	0	No.07
UNIT WORK NAME 8	52	0	No.08
UNIT WORK NAME 9	0	36	No.09

TOTAL 585 (RU)

OPERATOR 2

S12

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
UNIT WORK NAME 3	156	0	No.03
UNIT WORK NAME 4	34	0	No.04
UNIT WORK NAME 5	138	23	No.06
UNIT WORK NAME 10	71	48	No.10
UNIT WORK NAME 11	138	30	No.11
UNIT WORK NAME 12	97	20	No.12
UNIT WORK NAME 13	88	0	No.14
UNIT WORK NAME 14	46	18	No.15
UNIT WORK NAME 15	546	15	No.16
UNIT WORK NAME 17	58	20	No.17

TOTAL 1548 (RU) xxxxxx

OPERATOR 3

S13

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
UNIT WORK NAME 13	30	40	No.13
UNIT WORK NAME 16	303	131	No.18

TOTAL 572 (RU)

OPERATOR 4

S14

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
UNIT WORK NAME 19	84	26	No.19
UNIT WORK NAME 20	120	20	No.20
UNIT WORK NAME 21	310	66	No.21

TOTAL 6238 (RU)

OPERATOR 5

S15

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
UNIT WORK NAME 22	146	71	No.22
UNIT WORK NAME 23	106	26	No.23
UNIT WORK NAME 24	61	0	No.24
UNIT WORK NAME 25	51	10	No.25
END	0	0	No.X

TOTAL 486 (RU)

OPERATOR 6

S16

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
UNIT WORK NAME 22	146	71	No.22
UNIT WORK NAME 23	106	26	No.23
UNIT WORK NAME 24	61	0	No.24
UNIT WORK NAME 25	51	10	No.25
END	0	0	No.X

TOTAL 486 (RU)

PF 83.6% PARALLEL STATIONS PF 117.3%

PF 96.7% PF 95.2% PF 73.6%

PARALLEL STATIONS

G STANDARD NO. WORK NAME

MA-CHINE MANHOUR

COMPOSITION MODE: PRIORITY ORDER SCHEME

COMPOSITION EFFICIENCY 96.43%

NET COMPOSITION EFFICIENCY